

Process Sheet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:32:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31811

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN3235020935



AN 32 350 20935

WASHER

M104156 *



7/5/10 SP

Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
WASHER

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1 into D3188-1.

2-Open holes in D3188-1 body floor to Ø0.297".

3-Install inserts in D3188-1 as per Dwg D3188.

4-Open holes in D3187-1 aluminum floor to 0.250" per dwg D3187

5-Deburr holes in D3187-1

in 07/05/14

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/14 ①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*****D3187-1 floor only*****

Chemical Conversion Coat as per QSI 005 4.1

SB

07-05-15

①

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*****D3187-1 floor only*****

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M102316

m-h

07/05/15

①

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

in 07/05/16

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Description :

12.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)
neoprene foam
batch: B 30632

✓ mulo 7/05/16

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

~~mulo~~ mulo 7/05/16

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

n/a (PTO)
ml

15.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: 22365

PTO

16.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD
batch: 330210

17.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DECAL
batch: B 31127

18.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Batch: 30680

7/5/10 Sg

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector	
07/05/10	15	<u>Permanent Change</u> missing one Washer AN960 5D516 <u>m103641</u> for ball stud Done	ml EE	0705-16 0705-16	1 1	[Signature] [Signature]	[Signature] [Signature]	
0705-16	14.0	QCS remove. perm. Change. <i>f</i>	EE	0705-16	1	[Signature]	[Signature]	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/17
 QA: N/C Closed: _____ Date: _____

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Job Number: 31811

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: 113459

20.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: B30866

21.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B21490

22.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M103574

23.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M103585

24.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: 19633

7/6/10

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

this step separates hardware, previous steps is for body & floor*

N/A

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Job Number: 31811

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103585

27.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M103585

28.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M100993

29.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: 19639

30.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: B30681

31.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: B31127

32.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: B29021

7/5/10

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Job Number: 31811

Part Number: D350600241

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	D2585	Latch Clamp
------	-------	-------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch: B30814

34.0	D2621	Latch Plate
------	-------	-------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: B3111

35.0	MS27039115	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M102536

36.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M100743

37.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M104215

38.0	D28571	Hinge Bracket
------	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B29059

39.0	D28572	Hinge Bracket
------	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B31791

7/5/1059

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31811

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

D2228

Backing Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: B30679

41.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M103585

42.0

AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: M103585

43.0

MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M419633

44.0

D35571

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: B23126

45.0

AN526C832R44

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: 9216

46.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103585

7/5/10 sep

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Part Number: D350600241

Job Number:



Seq. #: Machine Or Operation: Description :

47.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled glass fibres 10% to weight

A/R Hysol batch: M103922 expire date: Mar 2008

A/R Milled fibres batch: M100859

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement Batch: M102565

ml 07/05/16 ^{xl}

48.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/16 ①

49.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: M103707

ml 07/05/16

50.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

ml 07/05/16

51.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

32424

52.0

D350600449

SWITCH RELOCATION KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH RELOCATION KIT

1331898 ✓

53.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label

1327863 ✓

7/5/16 SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31811

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

D35471

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: B3124 ✓ ✓

55.0

D35501

STRUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: B31148 ✓ ✓

56.0

D35527

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: B31149 ✓ ✓

57.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: B30210 ✓ ✓

58.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M103641 ✓ ✓

59.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: B22365 ✓ ✓

60.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C207105/17 ①

8/5/16 SA

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:32:38 PM
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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31811

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location:

PPP Rev: B

C 07/05/17 ①

62.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

SD 07/05/17

Job Completion



W 07-05-17

W/O:		WORK ORDER CHANGES					
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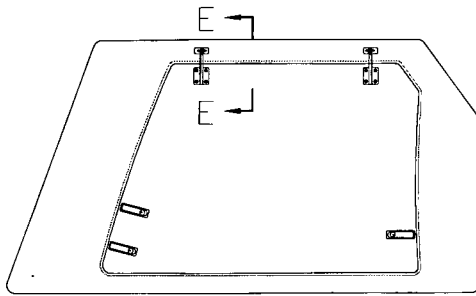


FIGURE 3. LOOKING AT OUTSIDE OF
D350-600-145 DOOR
(D350-600-146 SIMILAR AND OPPOSITE)

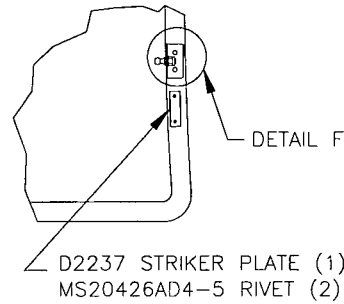


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

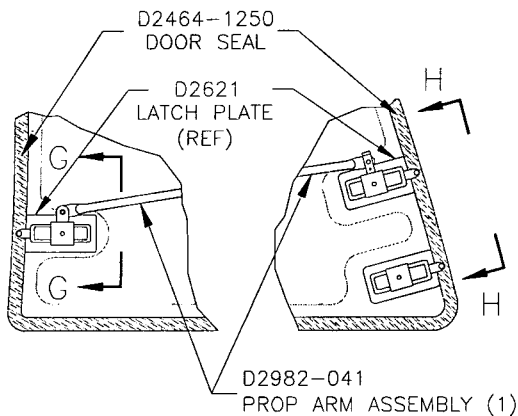
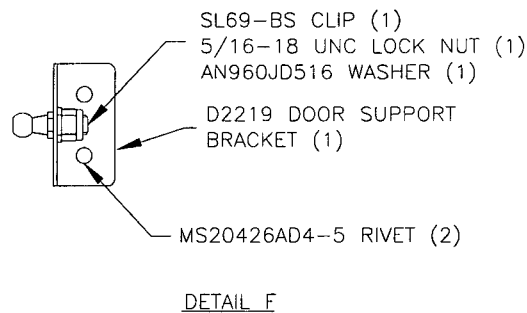


FIGURE 5. LOOKING AT TYPICAL INSIDE
OF D350-600-145/-146 DOOR



DETAIL F

TC Accepted

MAY 07 2003

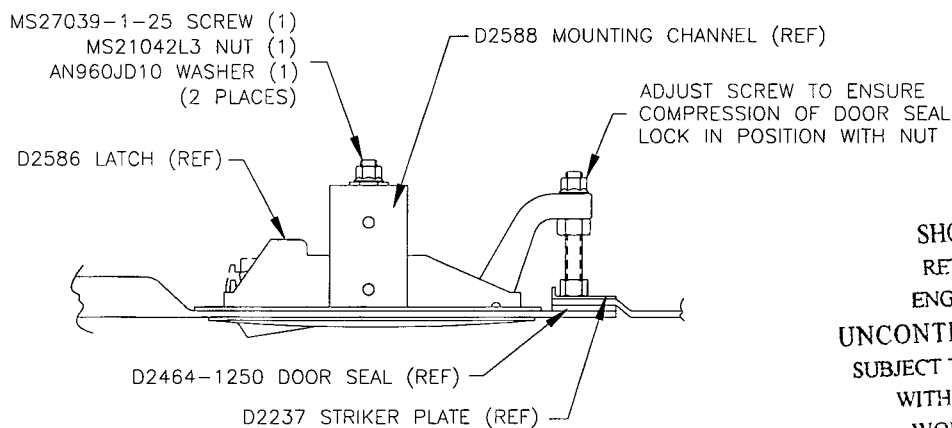
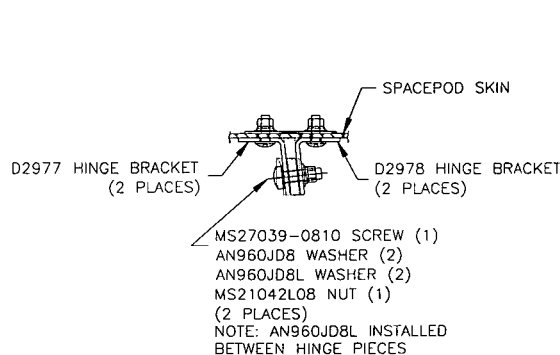
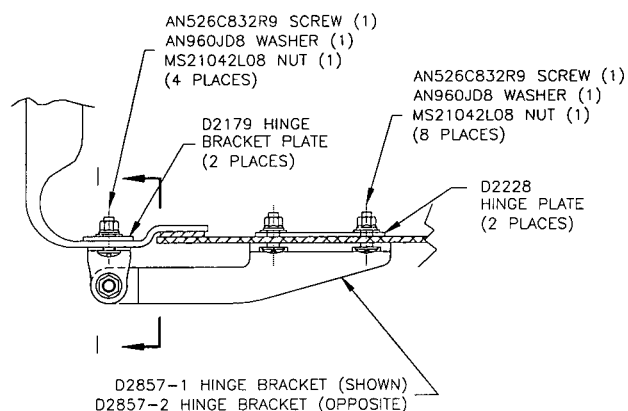


FIGURE 6. TYPICAL LATCH INSTALLATION

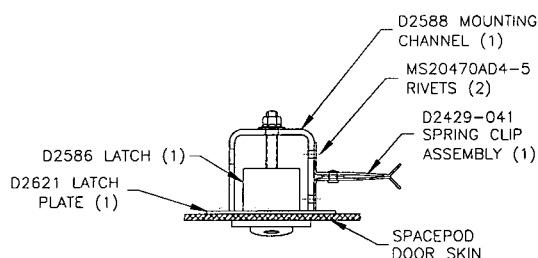
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31811



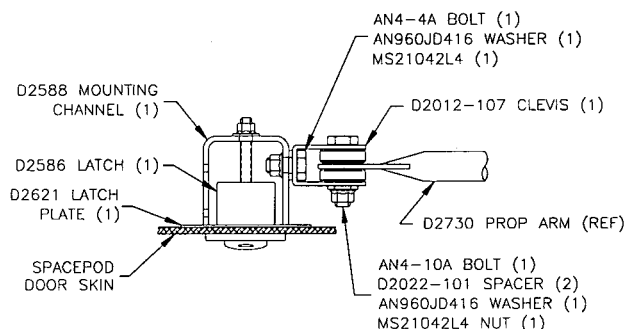
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



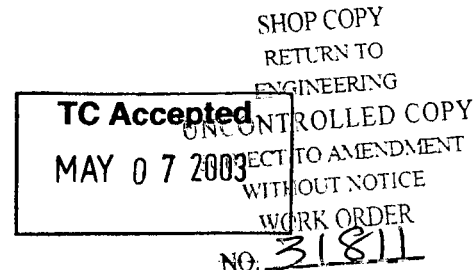
SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.



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25-00-00

DART

RELEASED

07.04.09

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	CB	DRAWING NO.	REV. E
CHECKED LE	APPROVED [Signature]	D3188	SHEET 1 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY	SCALE NTS	
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11	

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8500

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- 7) ALL DIMENSIONS ARE IN INCHES

- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
RETURN TO
ENGINEERING
WITHOUT NOTICE
WORK ORDER
NO. 31811

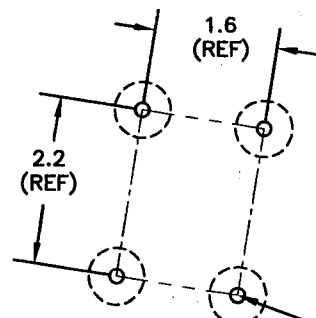
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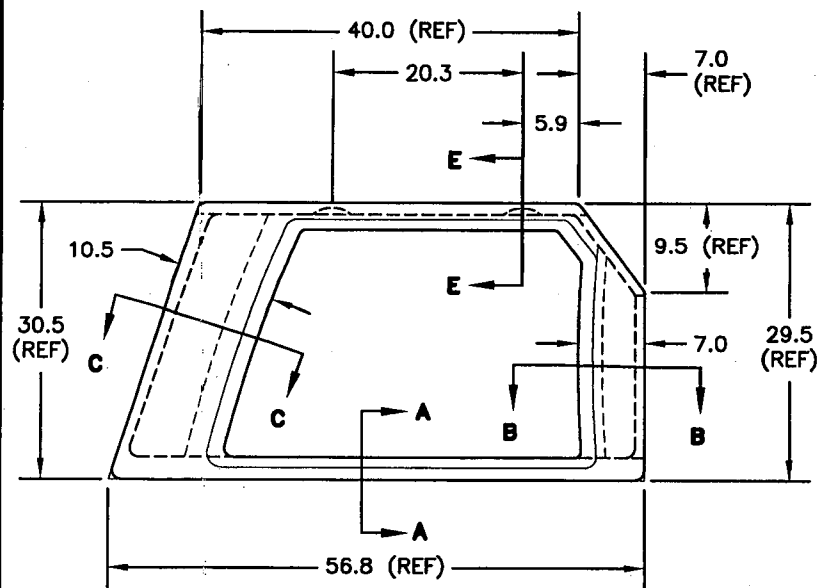
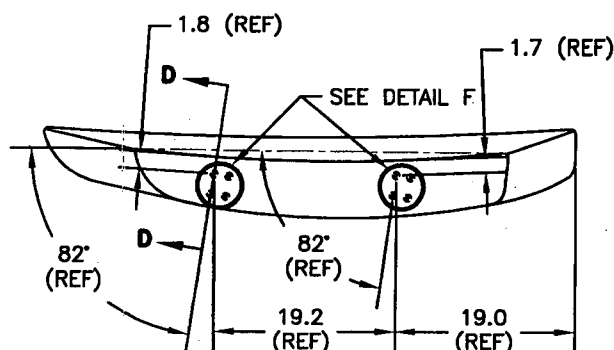
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DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 2 OF 11
		SCALE	NTS	

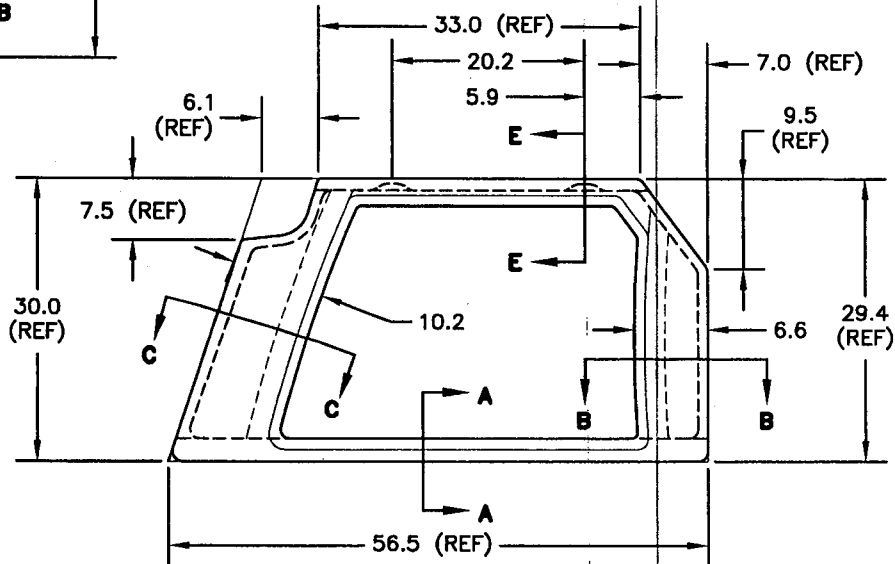
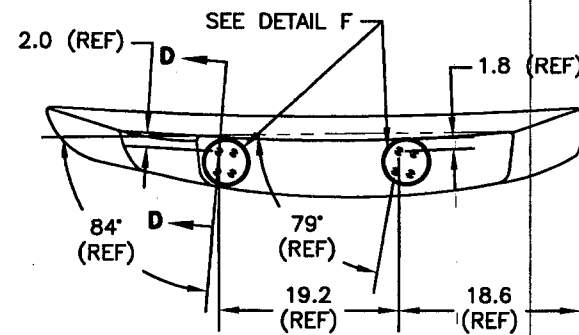


DETAIL F

INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

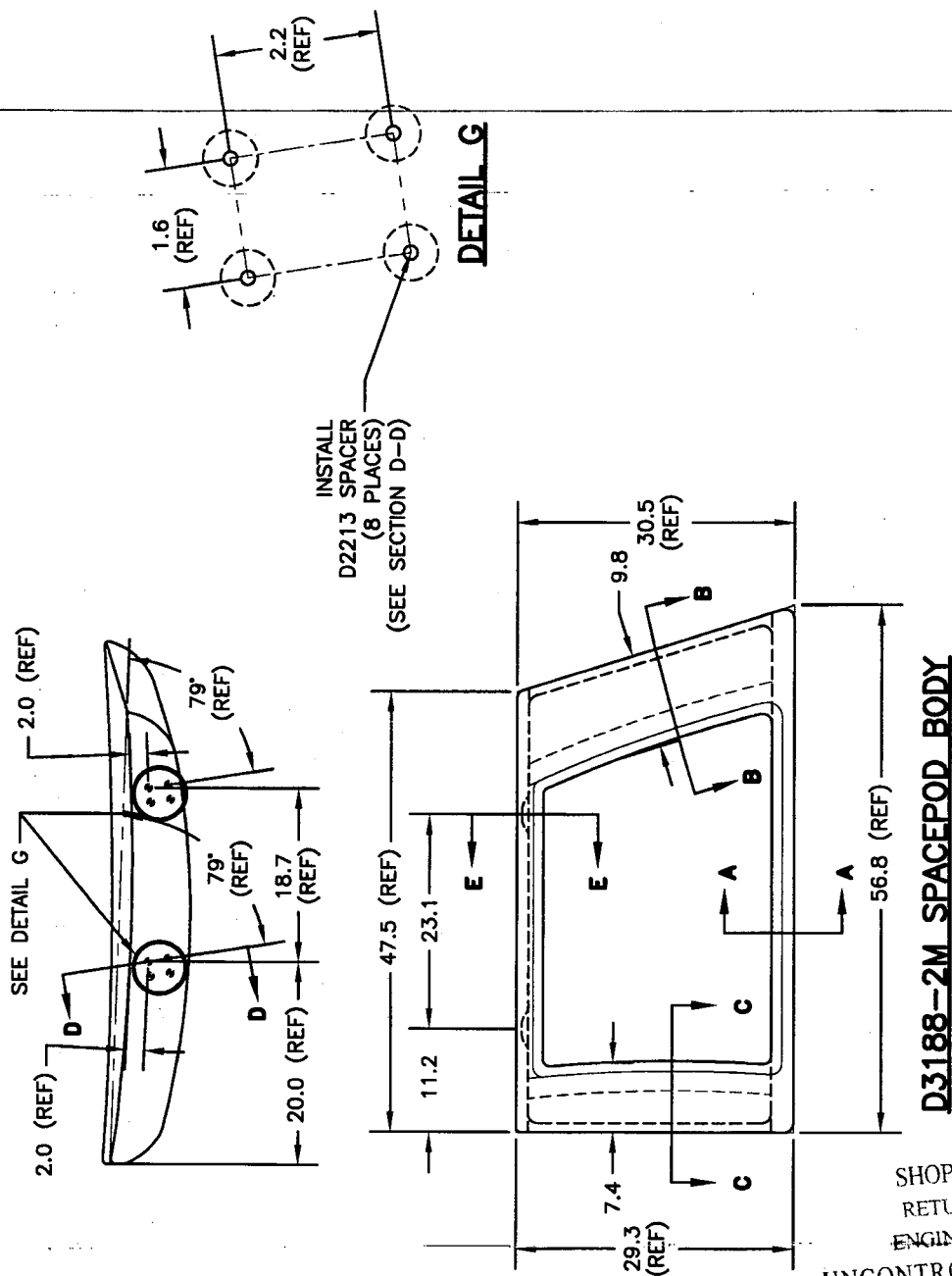
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D3186-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

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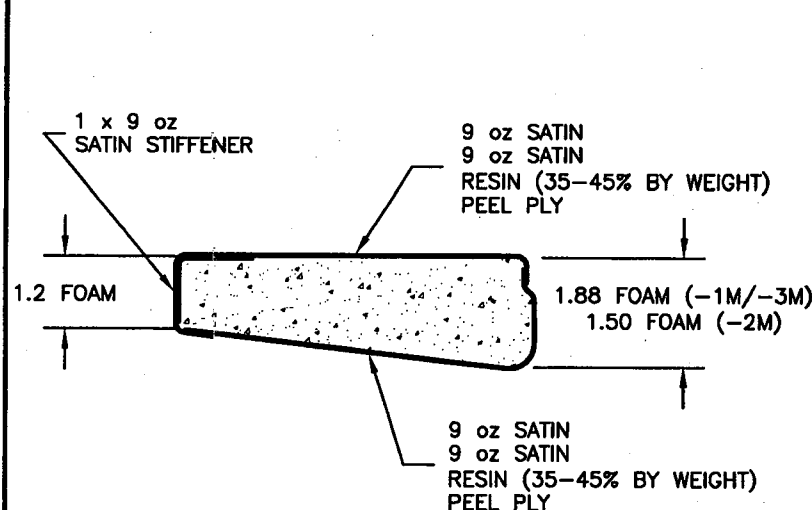
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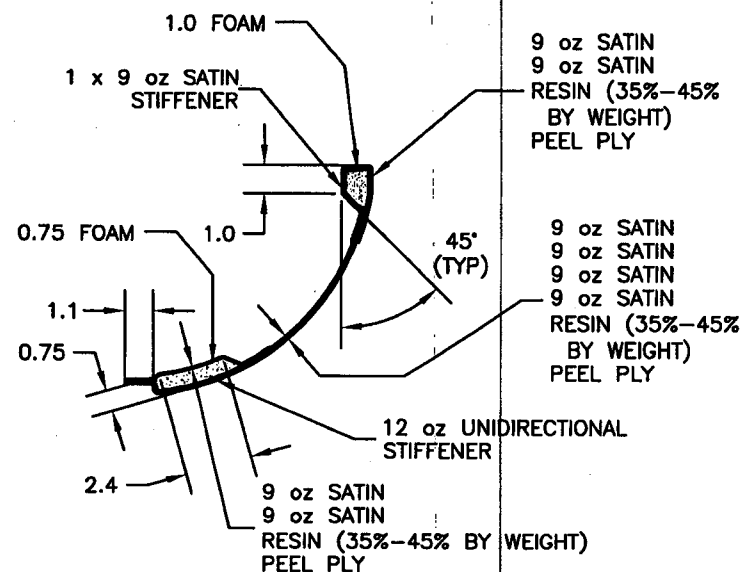
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		TITLE	SPACEPOD BODY	SHEET 4 OF 11
		SCALE	NTS	

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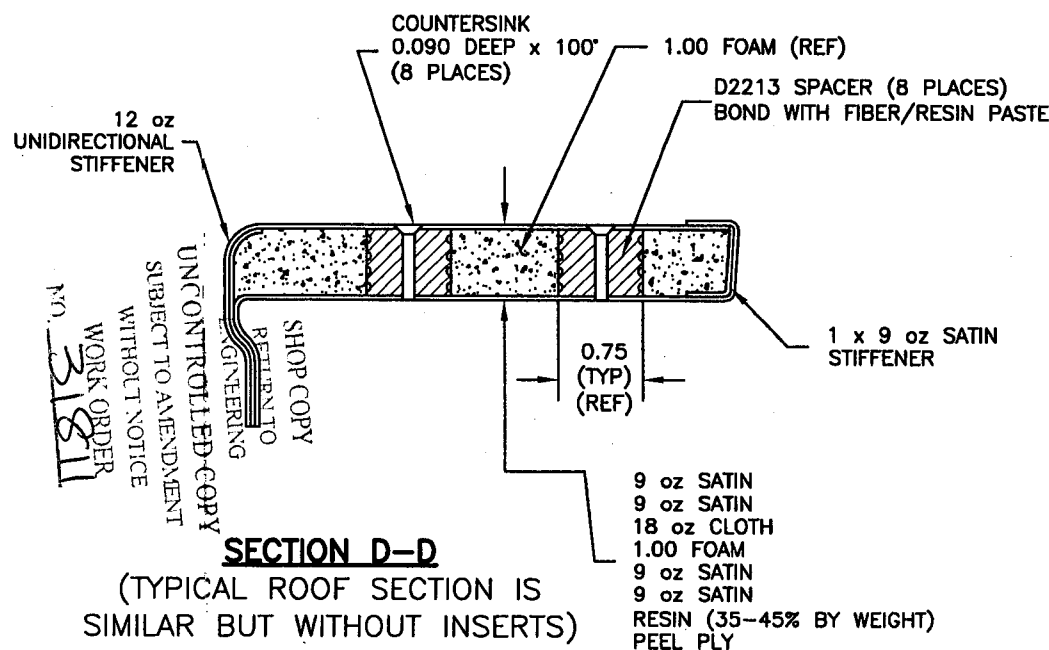
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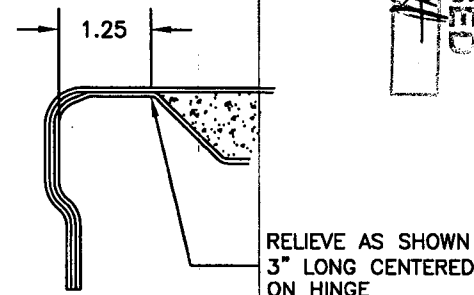
SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

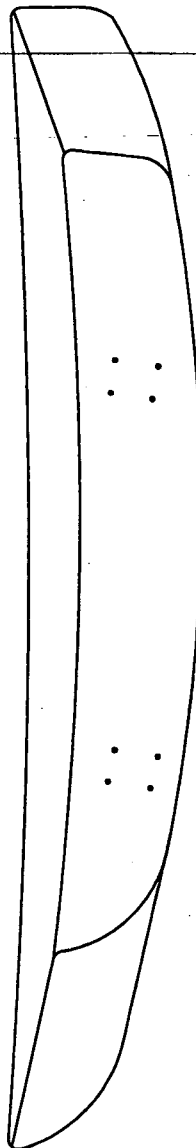
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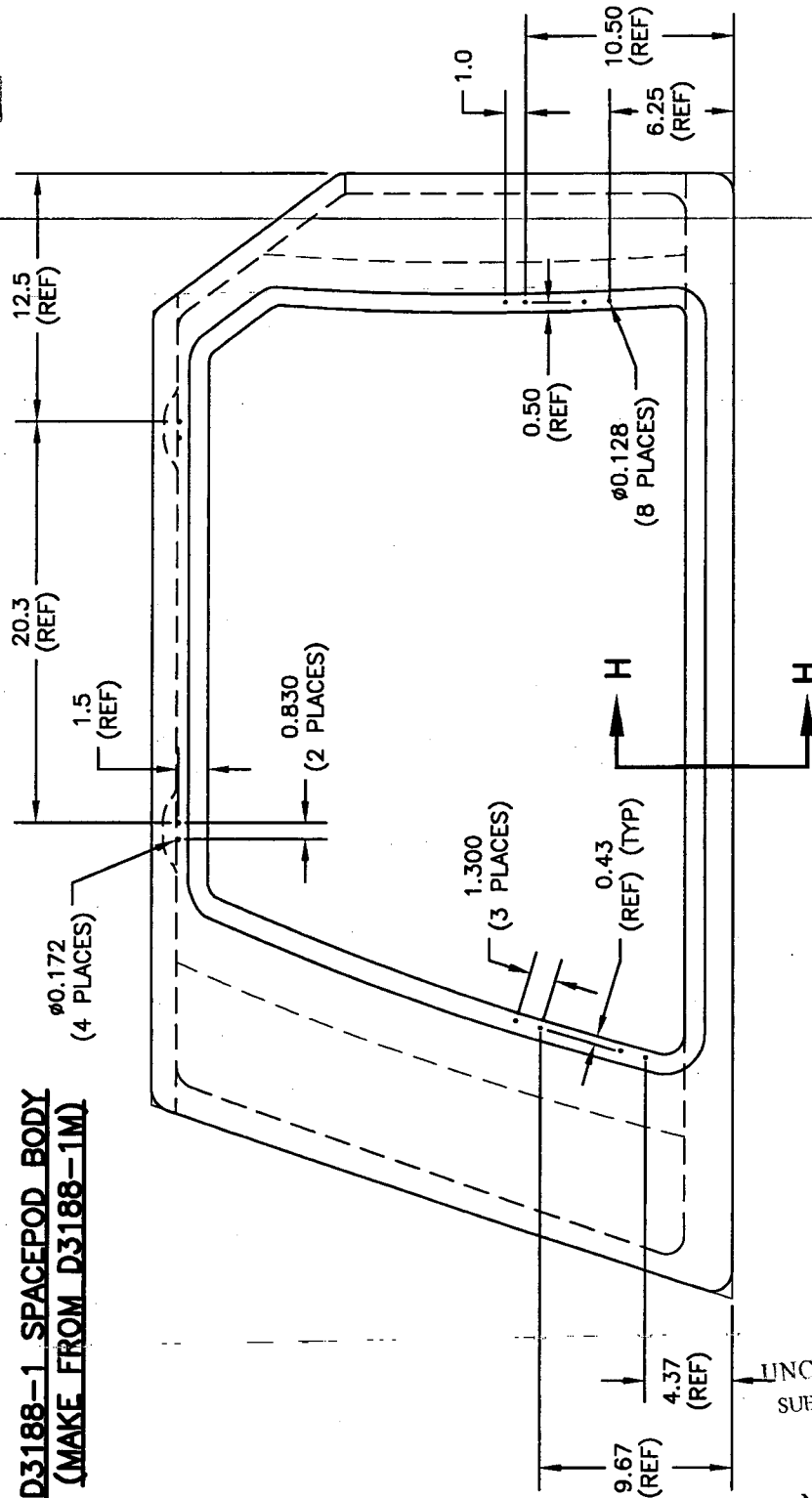
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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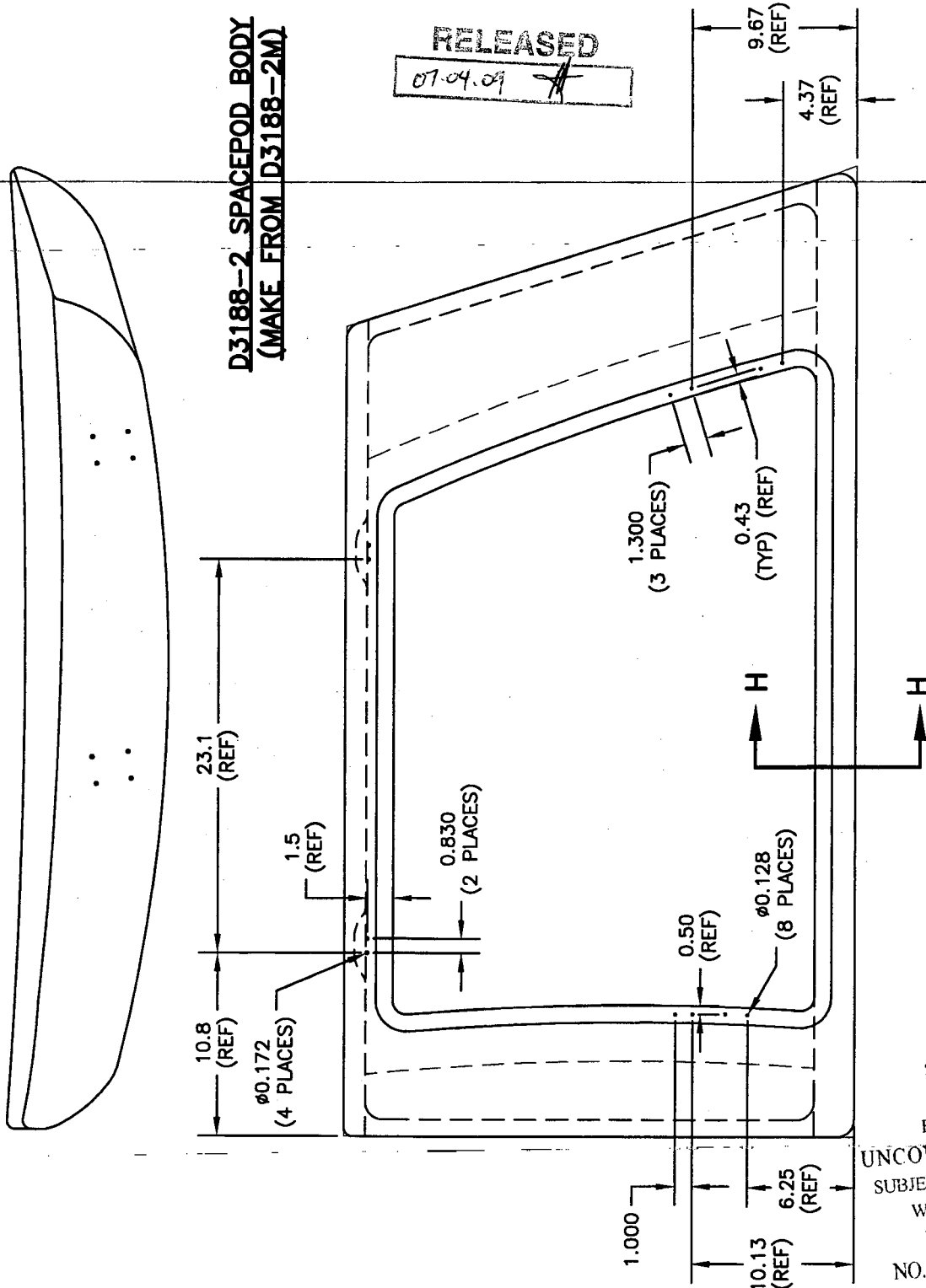
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



NOTES:
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TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
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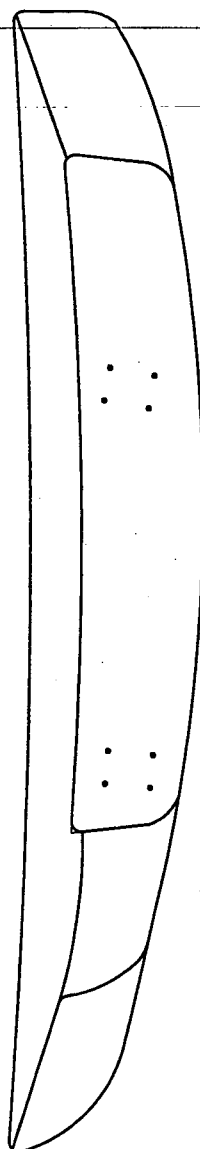
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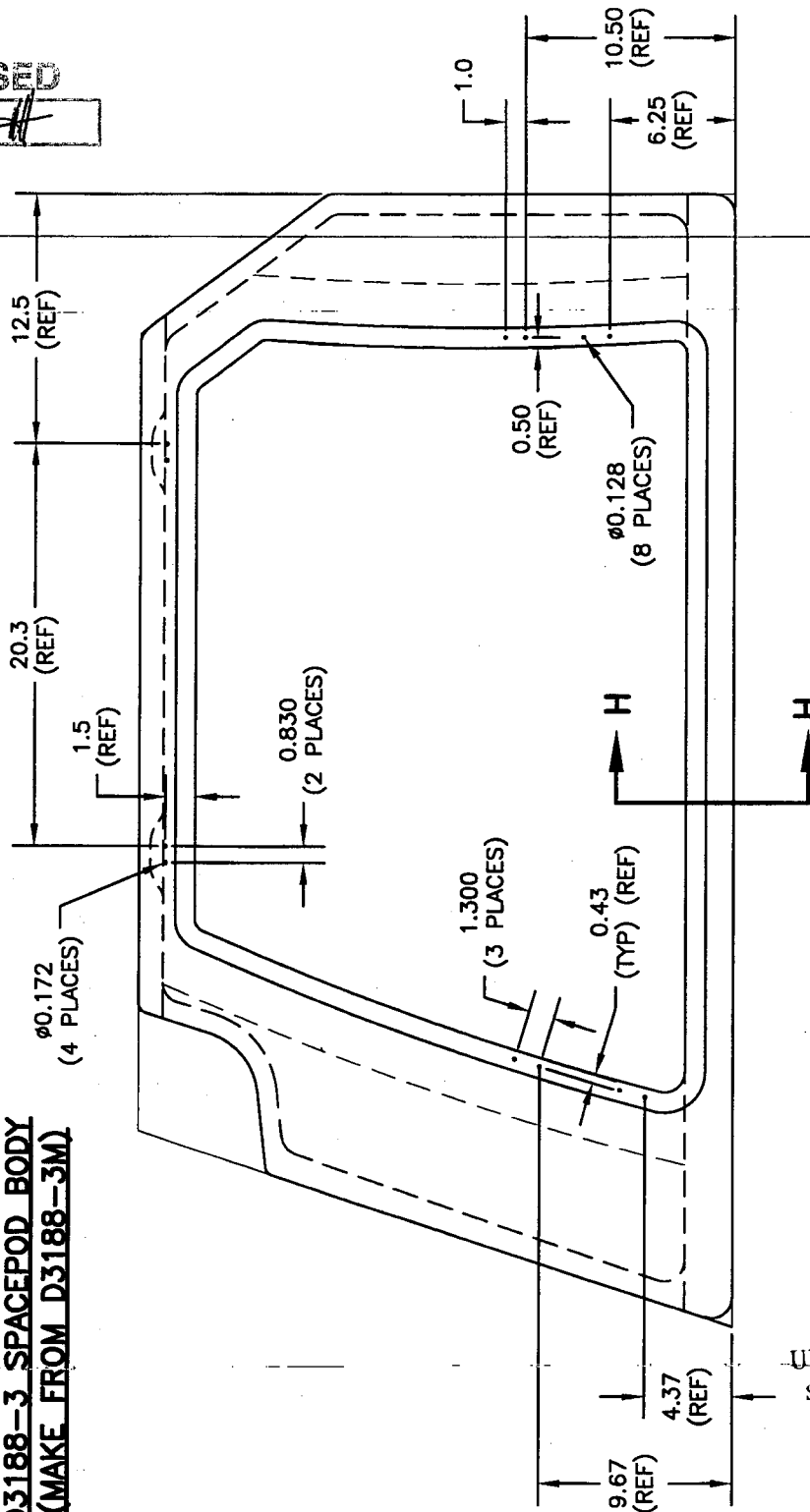
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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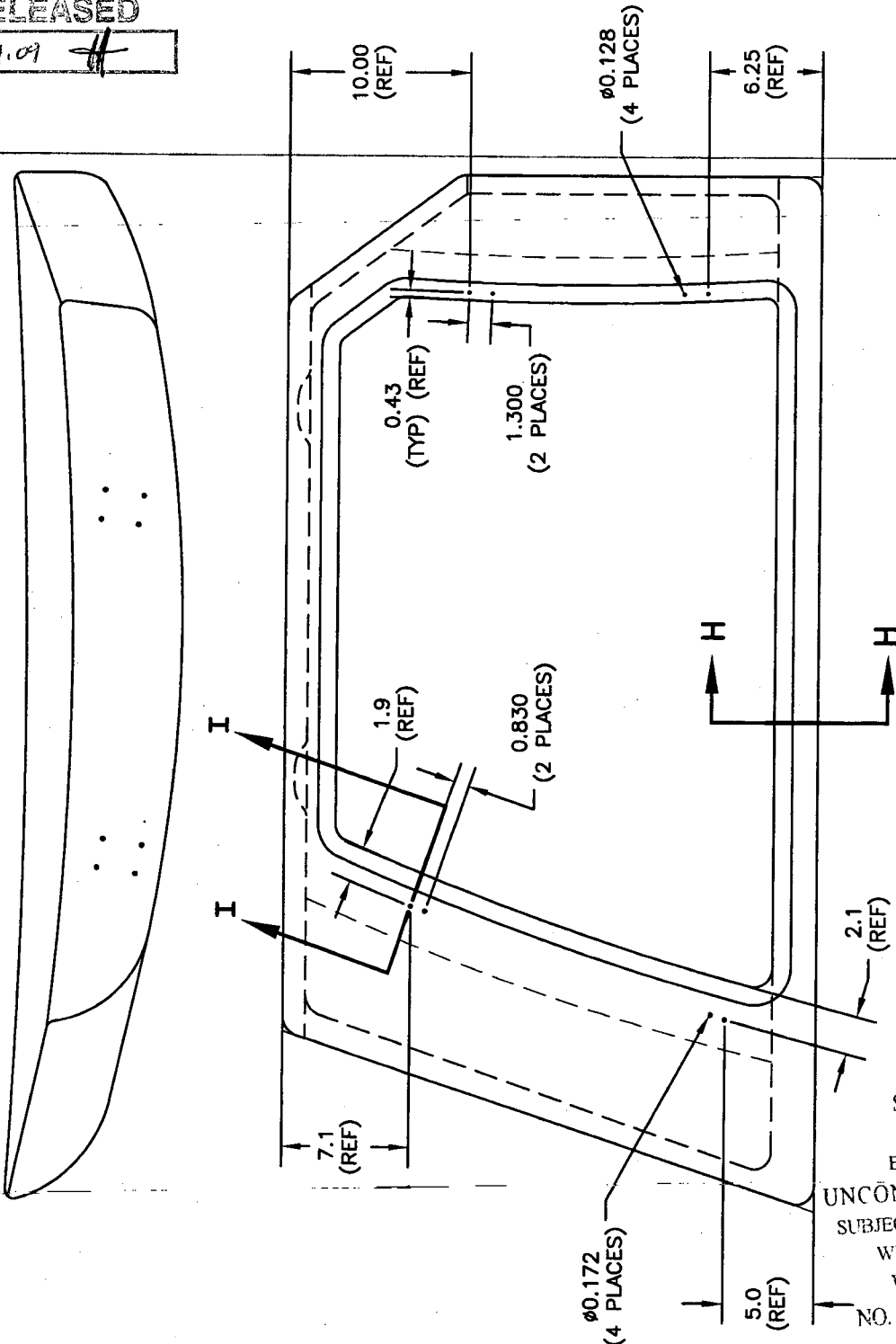


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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)**



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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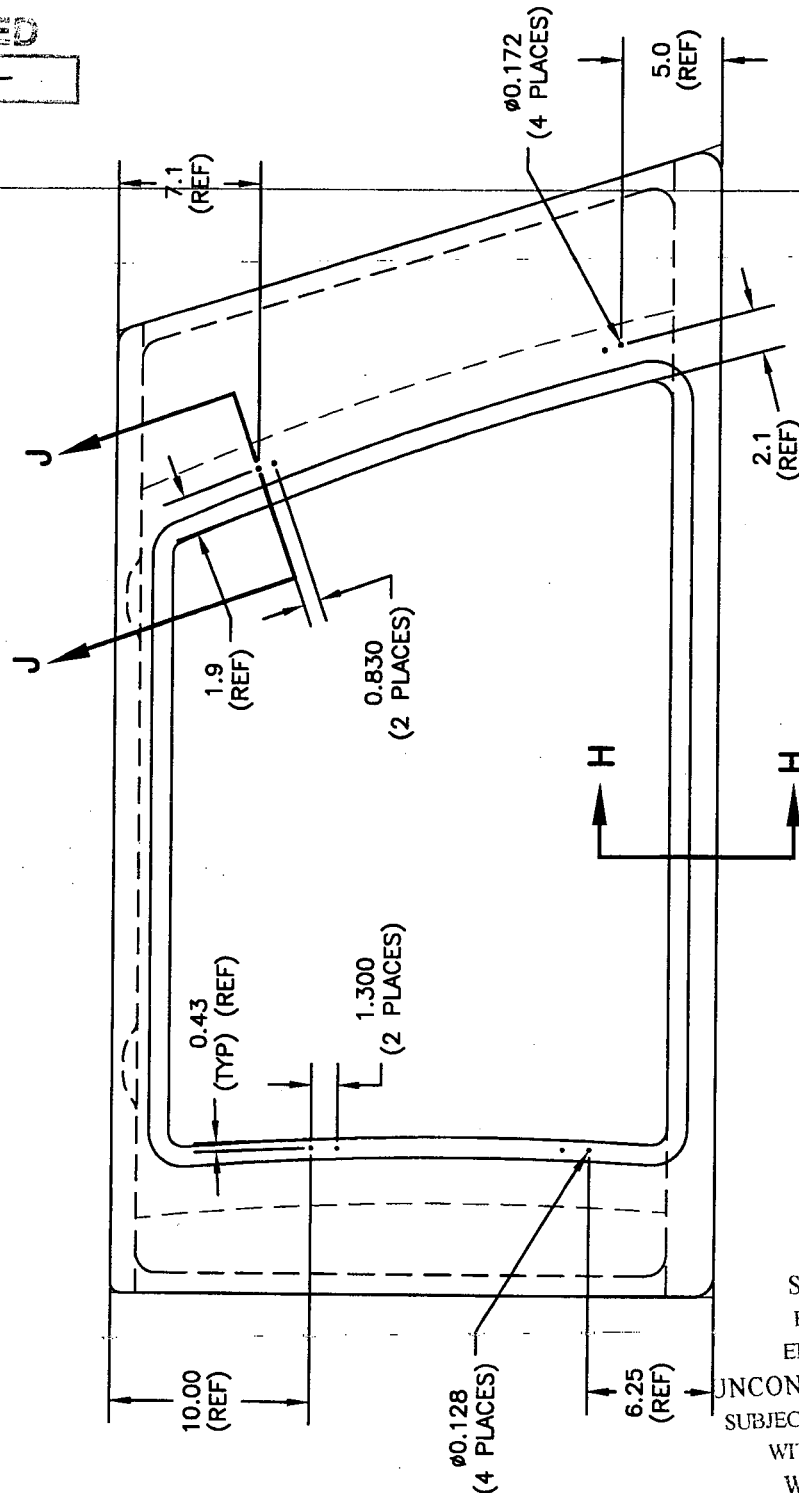
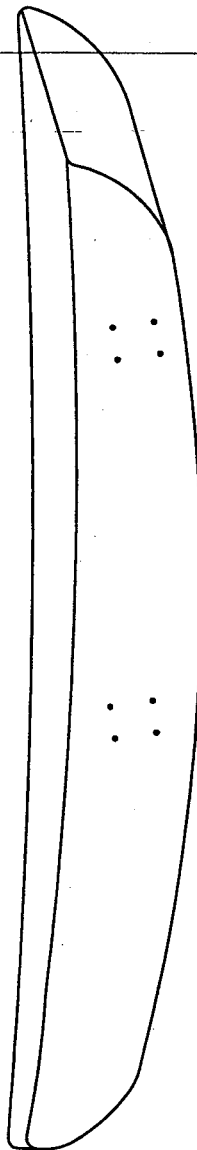
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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07.04.09

**D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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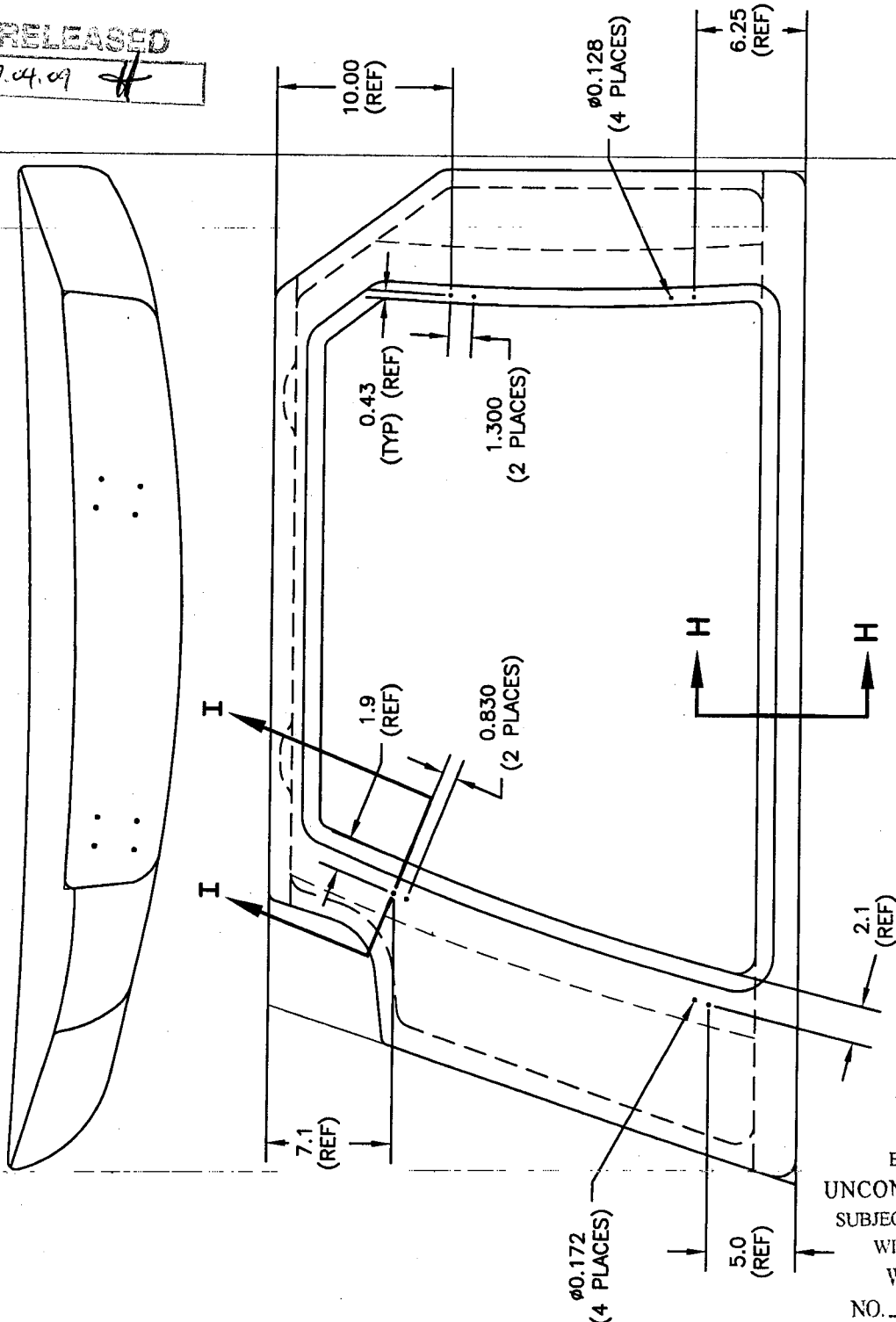
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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07.04.09 **[Signature]**

**D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)**



- NOTE:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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07.04.02

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)

SECTION H-H

(TYPICAL FLOOR SECTION)



SPACEPOD INNER SKIN

HYSOL 934NA W/
MILLED GLASS FIBRES
OR METALSET A4

Ø0.172

Ø0.38

FOAM
(REF)

0.25

SPACEPOD OUTER SKIN

SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Thursday, 4/12/2007 8:00:29 AM
 User: Kim Johnston











Process Sheet

16

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY LH/ DSI 9335
Job Number	: 31811		
Estimate Number	: 12775		
P.O. Number	:	Part Number	: D350600241
This Issue	: 4/12/2007 S.O. No. :	Drawing Number	: D3188,ICA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: E/2
Previous Run	: 31768	Material	:
Written By	:	Due Date	: 4/19/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>JA 07.04.12</u>		
Comment	: Est Rev. 07.03.07 new issue ec		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		
Comment: DOCUMENT CONTROL Photocopy bluefile and type labels as per PPP D350-600-241 CHG001		
2.0	31811A	SWITCH RELOCATION KIT
		
Comment: Sub-Component SWITCH RELOCATION KIT		
3.0	31811B	SPACEPOD BODY LH
		
Comment: Sub-Component SPACEPOD BODY LH D3188-1M Batch: _____		
4.0	31811C	SPACEPOD DOOR LH
		
Comment: Sub-Component SPACEPOD DOOR LH		
5.0	D31871	Spacepod Floor
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3187-1 Floor _____ 1 D3186-3 Door (ref) _____ 1 D3188-1 Body(ref) _____		

REFERENCE ONLY

Date: Wednesday, 12/20/2006 1:45:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD BODY LH
Job Number : 30022	
Estimate Number : 12595	
P.O. Number : <i>N/A</i>	Part Number : D31881M
This Issue : 12/20/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3188 REV <i>BC LE 07.01.18</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : <i>BC LE 07.01.18</i>
Previous Run : 30021	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/20/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i> 061220	
Comment : Est Rev:A New issue ecn882 06-11-30 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

8 D2213 Spacer Batch: *B25325 C20701102 (8)*

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING
 Issue P/O: *2767*
 Description: D3188-1 BODY *C206112121 (1)*
 Ship: D2213 Spacers
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship 2 Items from Previous steps

3.0	D31881P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

[Signature] 1/15/9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 02/05/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:45:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 30022

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 . Visual inspection. Check for void spot and pins.

ml 07/05/09

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/05/09

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107 07/05/17

Job Completion



U 07/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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06.12.13		D3188
		SHEET 1 OF 11
		SCALE
		NTS
		TITLE
		SPACEPOD BODY
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES

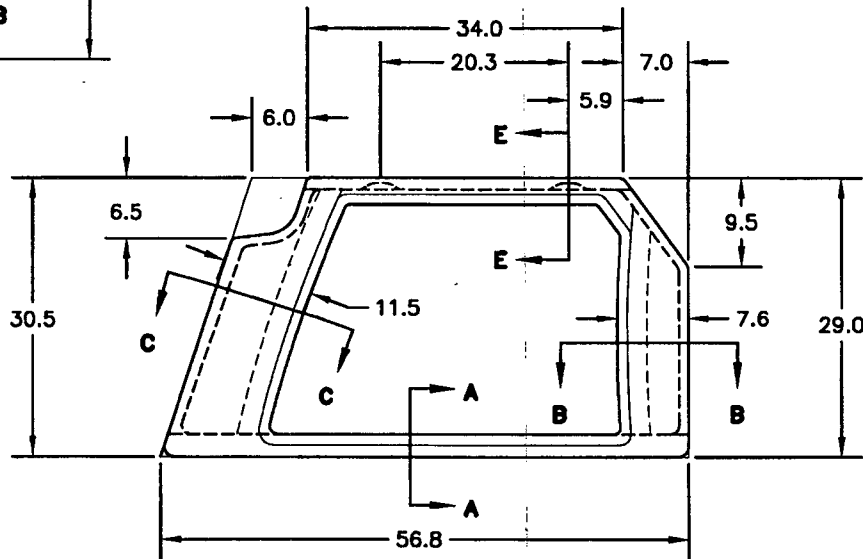
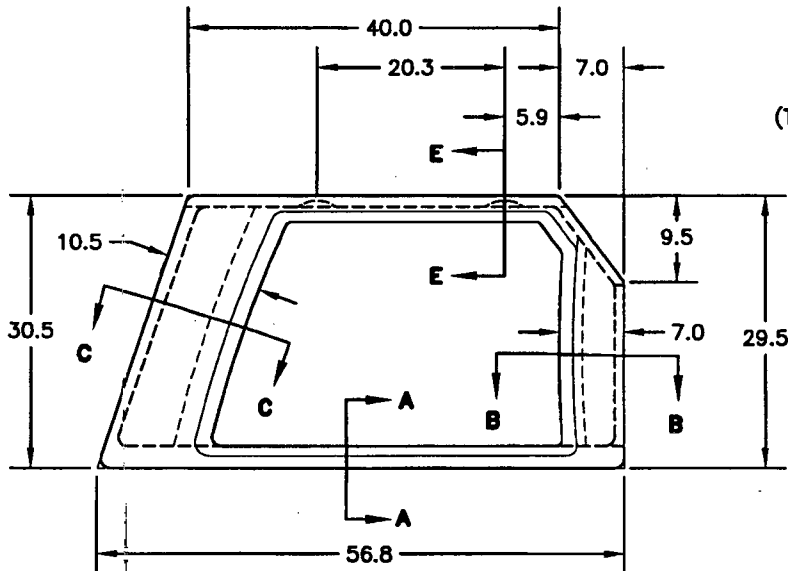
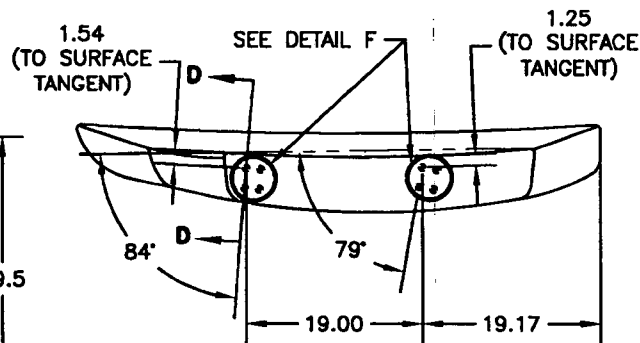
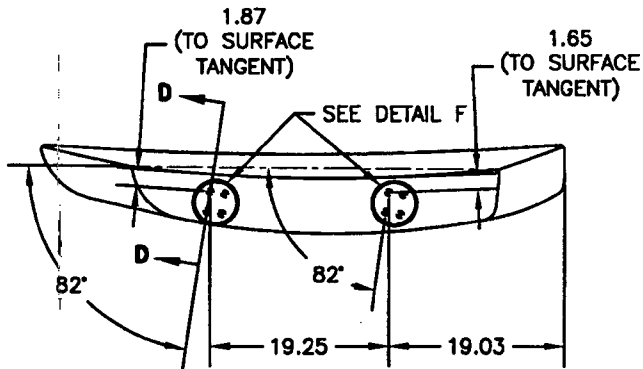
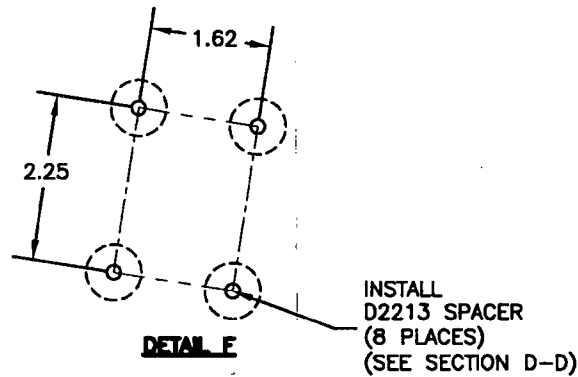
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DATE	06.12.13	DRAWING NO.	D3188	REV. C
		TITLE	SPACEPOD BODY	SHEET 2 OF 11
				SCALE
				NTS



D3188-1M SPACEPOD BODY

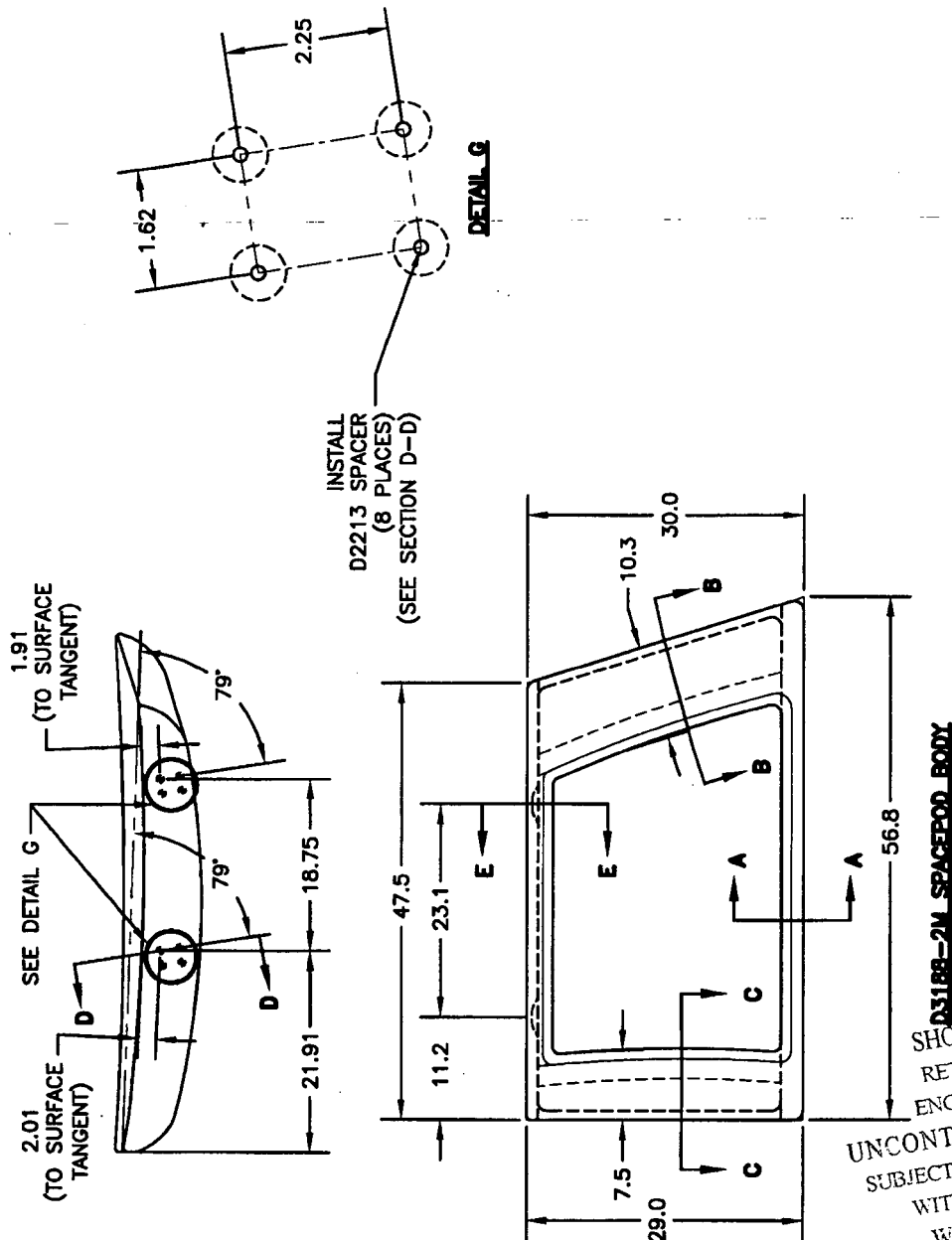
D3188-3M SPACEPOD BODY

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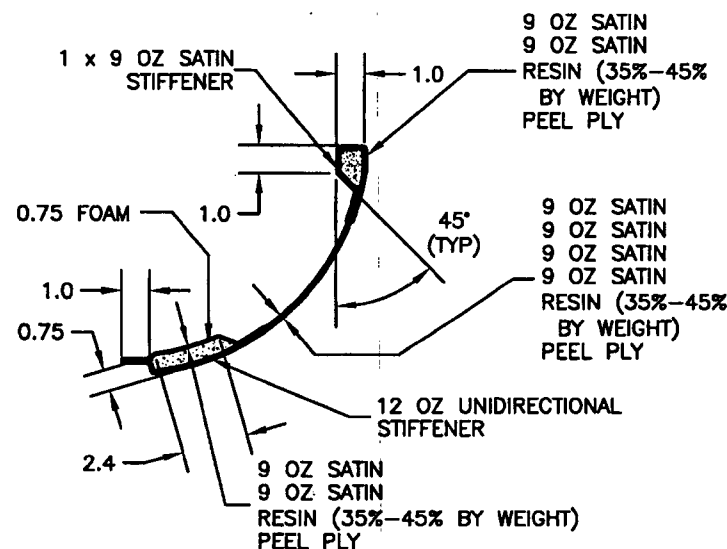
NOTE:
SEE SHEET #4 FOR SECTION VIEWS

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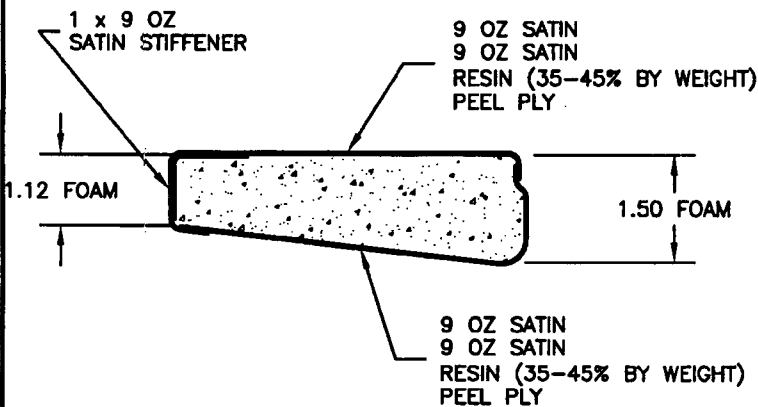
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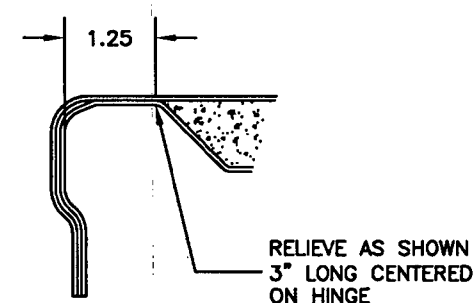
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CHECKED	SH	APPROVED	SH	HAWKESBURY, ONTARIO, CANADA	
DATE	06.12.13	DRAWING NO.	D3188	TITLE	SPACEPOD BODY
				SCALE	NTS
				SHEET 4 OF 11	REV. C



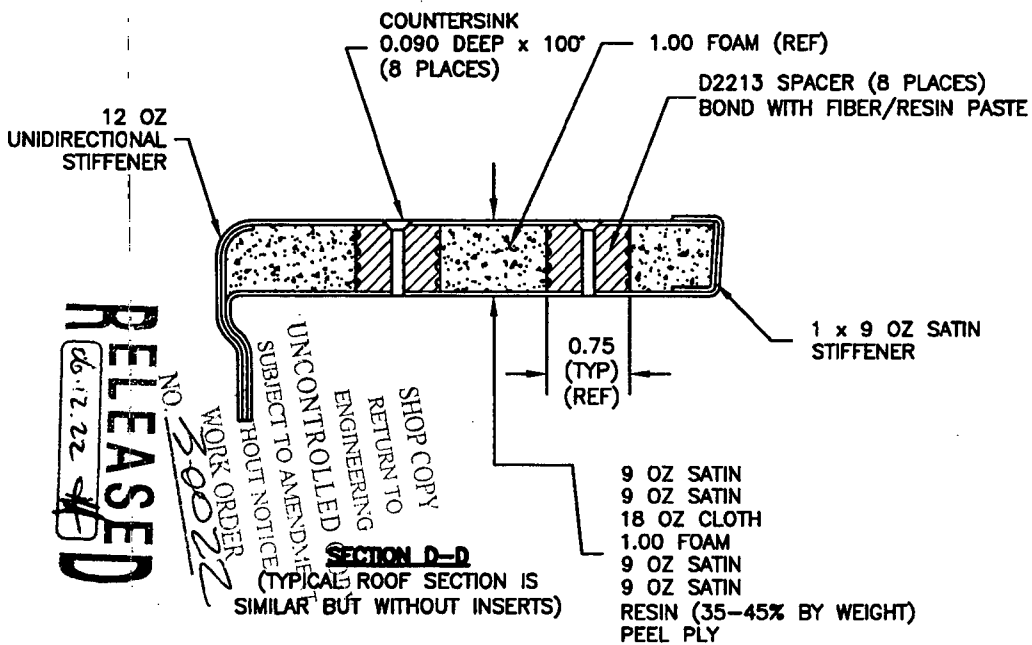
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION E-E
(2 PLACES PER POD)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)

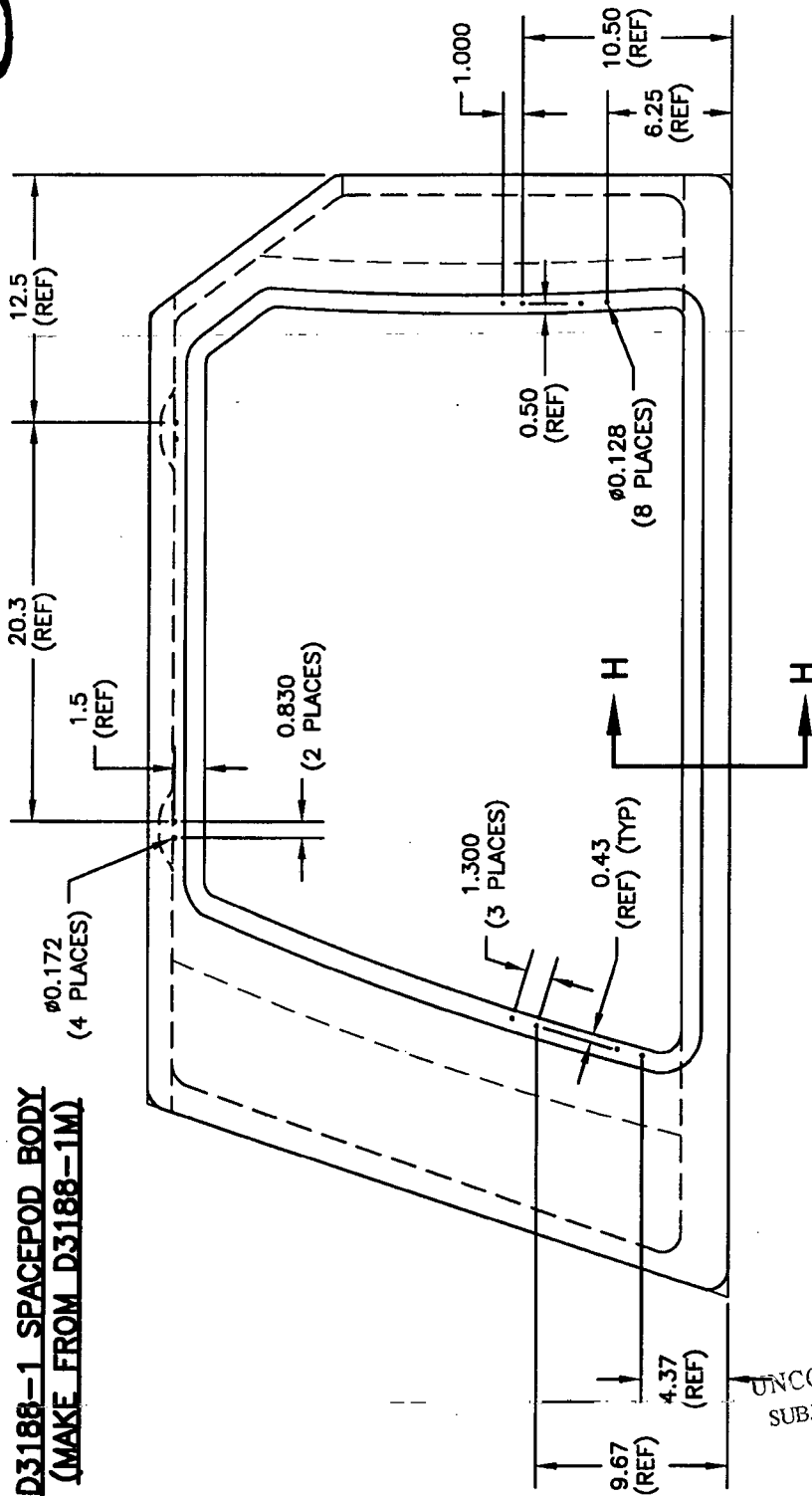
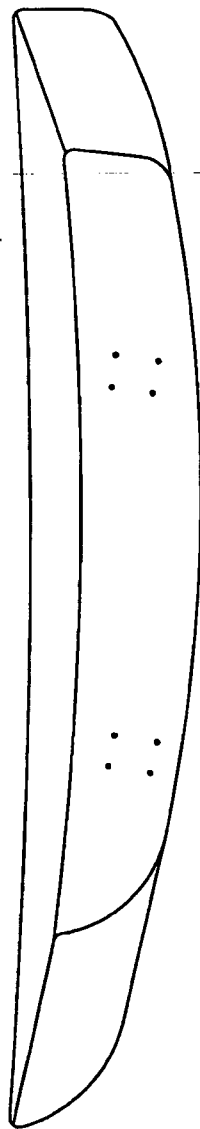
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06.12.22

WORK ORDER
NO. 30022
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**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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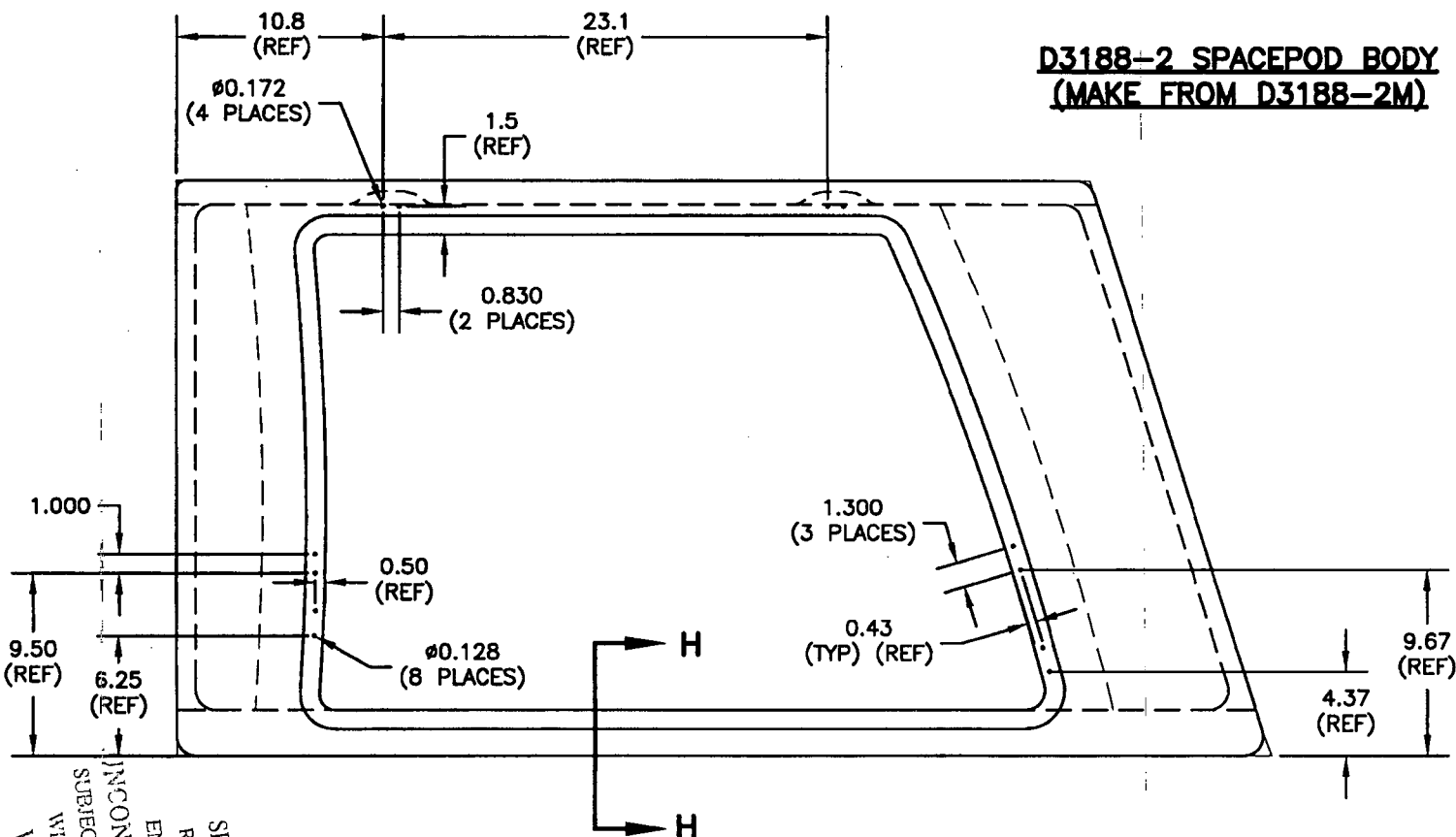
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**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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JB	CE	SPACEPOD BODY	D3188	SHEET 6 OF 11
CHECKED PH	APPROVED H	DATE 06.12.13		SCALE NTS

HAWKESBURY, ONTARIO, CANADA

DART AEROSPACE LTD

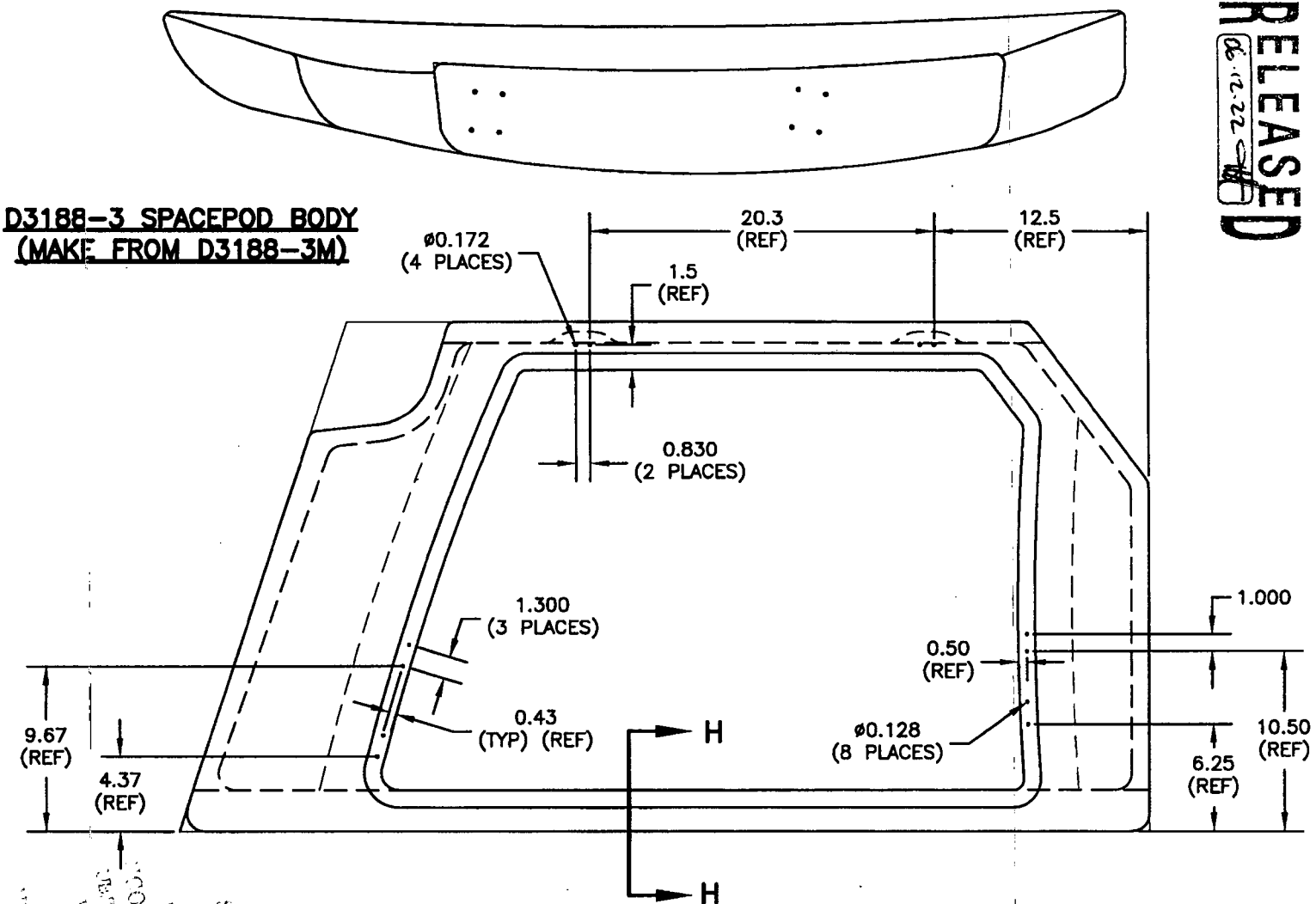
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PH	AK	D3188	SHEET 7 OF 11
DATE	TITLE	SCALE	
06.12.13	SPACEPOD BODY	NIS	



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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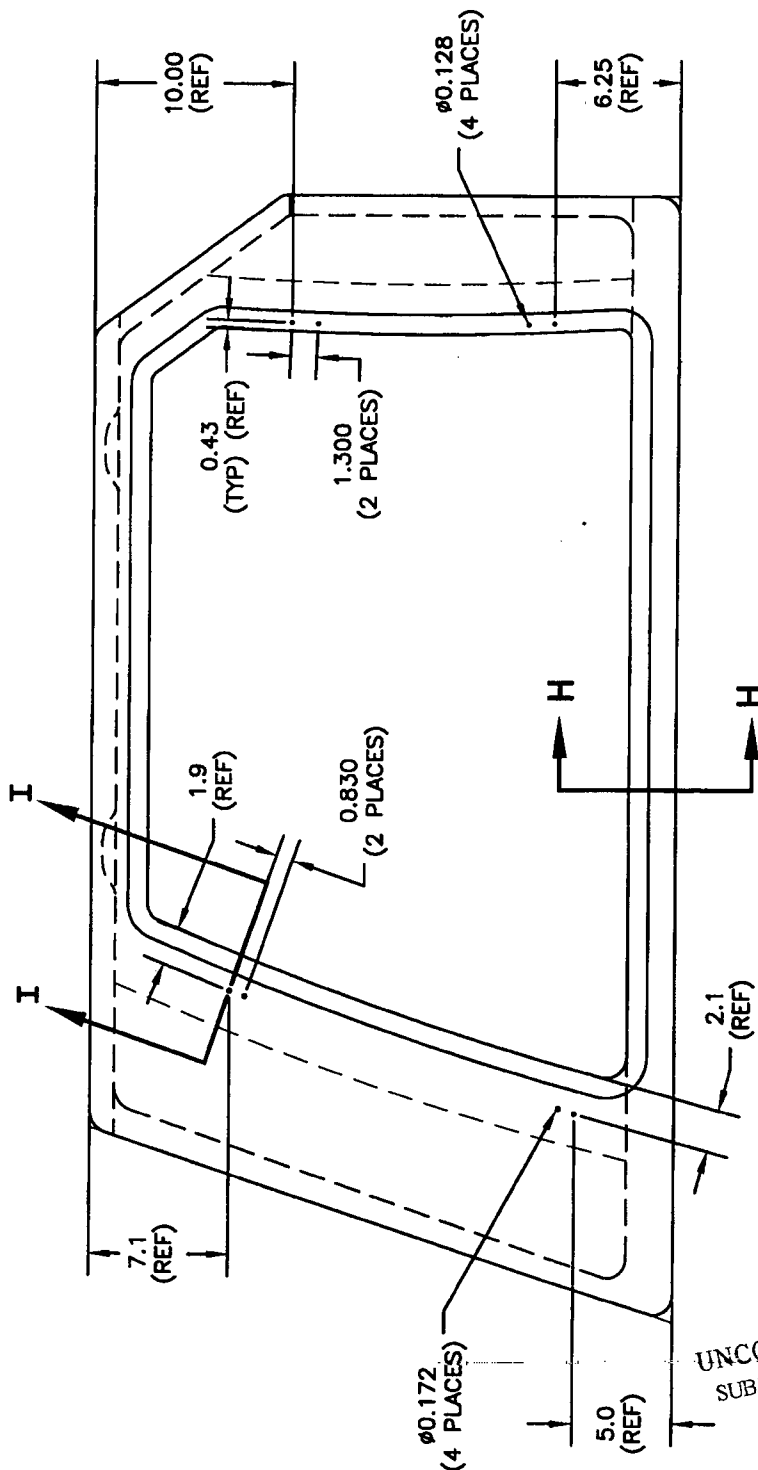
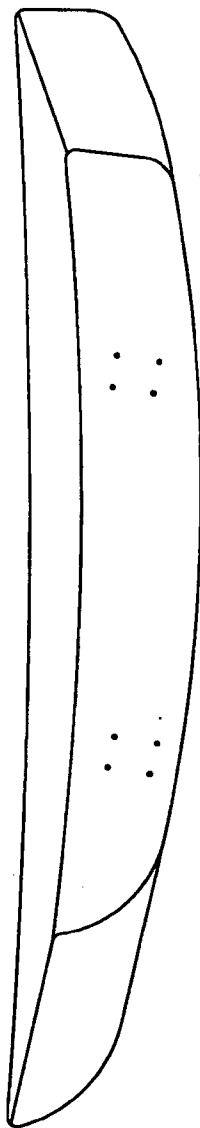
WORK ORDER
30022



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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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WORK ORDER
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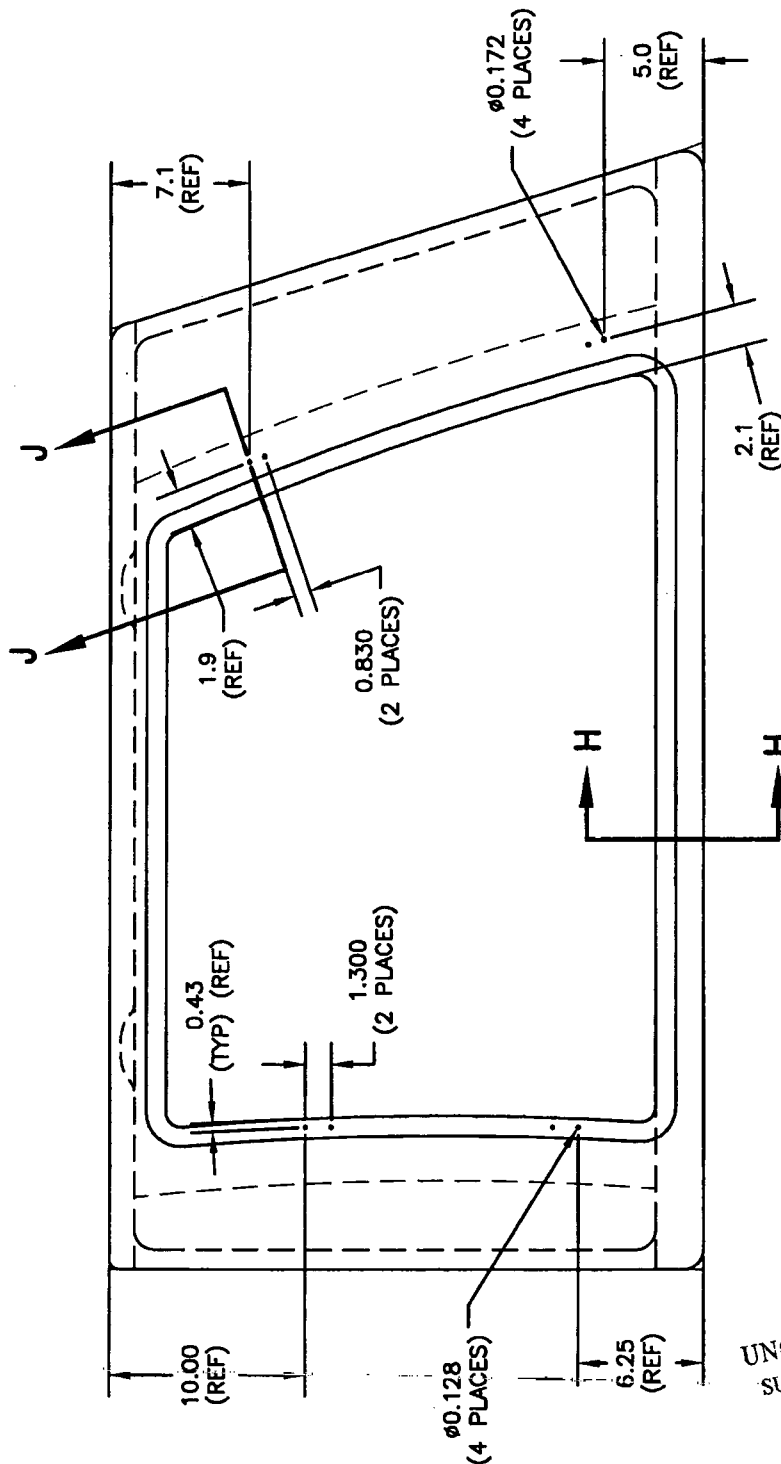
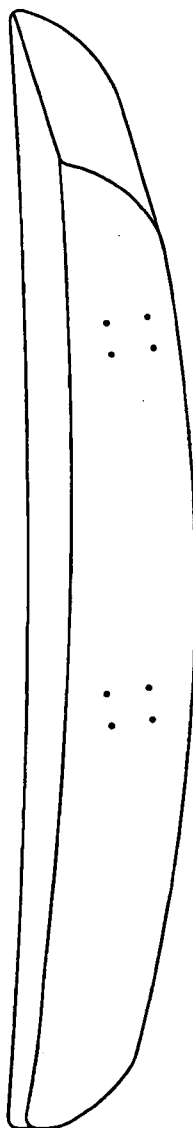
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22 [Signature]

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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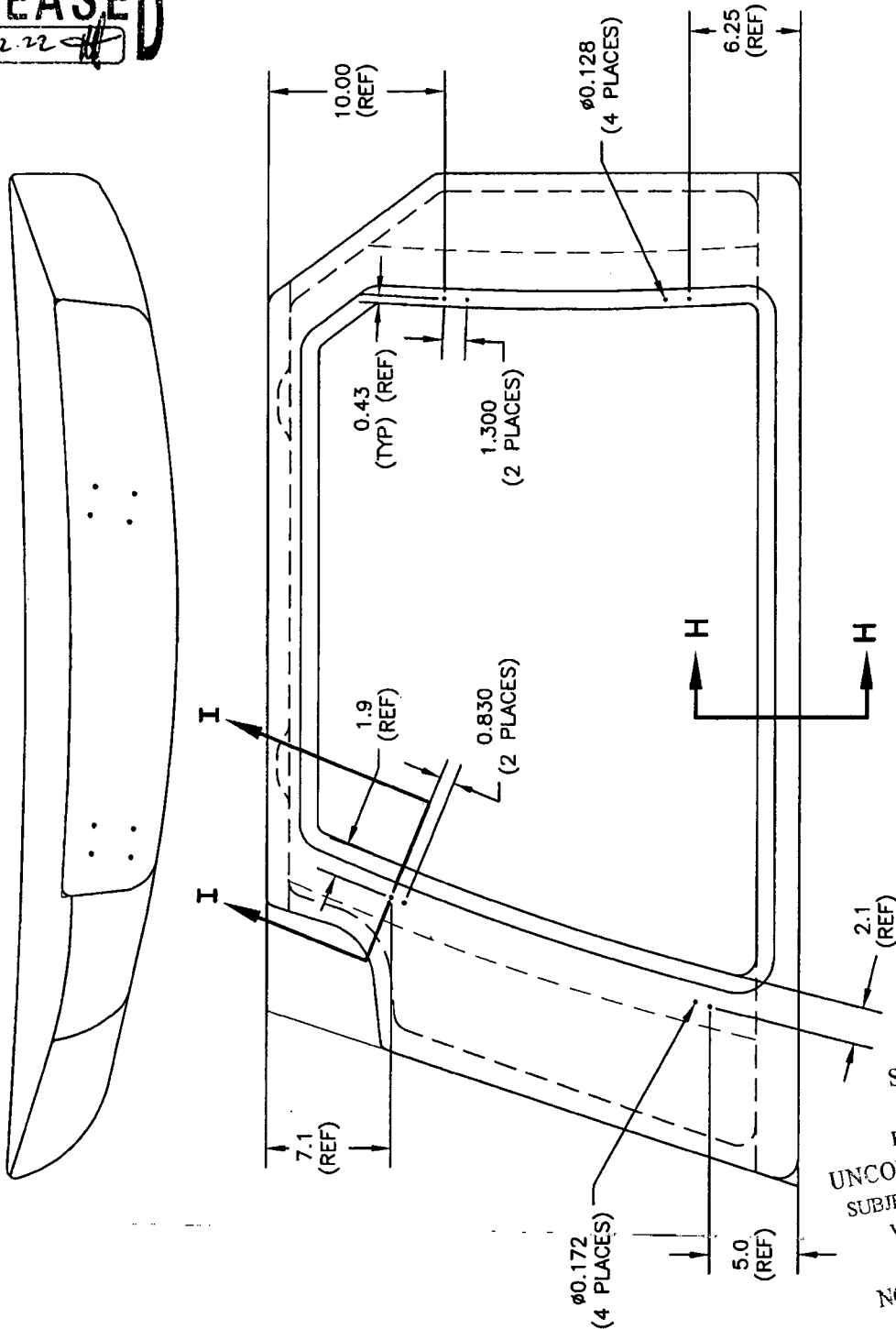
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

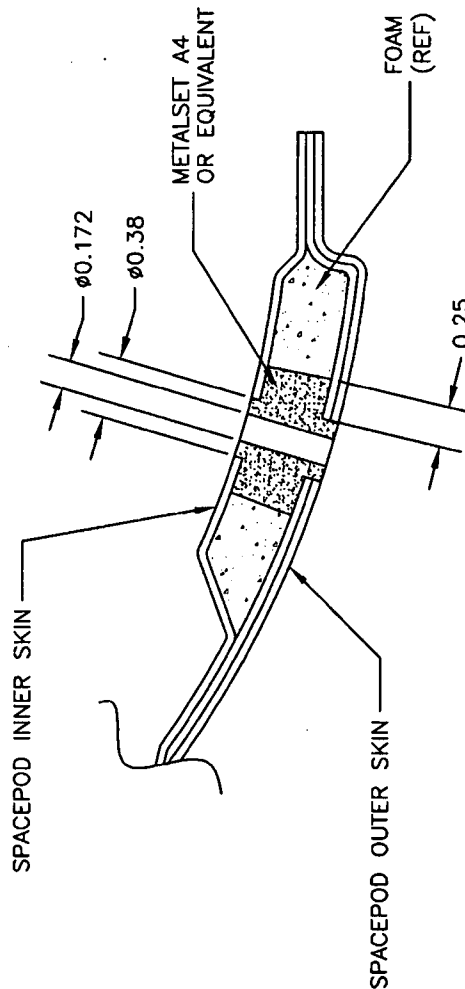
RELEASED
06.12.22

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11897
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
03/05/2007	21/12/2006	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30012 Dwg. Rév.: C Job: 41396 U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30022 Dwg. Rév.: C Job: 41110 U de M : Each			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30032 Dwg. Rév.: C Job: 41327 U de M : Each			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30042 Dwg. Rév.: C Job: 41100 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Monday, 4/16/2007 2:32:43 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD BODY LH
Job Number : 31811A	
Estimate Number : 12595	
P.O. Number :	Part Number : D31881M
This Issue : 4/16/2007 S.O. No. :	Drawing Number : D3188 REV.E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 31811B	Material :
Written By : <u>[Signature]</u>	Due Date : 4/23/2007 Qty: 1 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: A New issue ecn882 06-11-30 EC	
est rev B revc dwg 07.01.11 ec	
est rev C revD dwg 07.03.07 ec	
est rev D rev E dwg 07.04.16 EC	

Additional Product

Job Number:



w/o 30022

Seq. #: Machine Or Operation: Description :

1.0 D2213 Aluminum Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Ship To Delastek

8 D2213 Spacer Batch: _____

2.0 PG PURCHASING



Comment: PURCHASING
Issue P/O: _____
Description: D3188-1M BODY
Ship: D2213 Spacers
Supplier: Delastek
Conformity Certificate and Process sheet required
Ship 2 Items from Previous steps

3.0 D31881P Spacepod Body



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Body

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:32:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 31811A

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



WOTUS.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CE	[Signature]	D3188		SHEET 1 OF 11	
DATE		TITLE		SCALE	
07.04.02		SPACEPOD BODY		NTS	
A	03.04.03	NEW ISSUE			
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7			
C	06.12.13	REMOVED D0600-XXX LABELS			
D	07.02.22	UPDATE DIMENSIONS			
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11			

GENERAL NOTES:

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERA KANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8500

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- ALL DIMENSIONS ARE IN INCHES

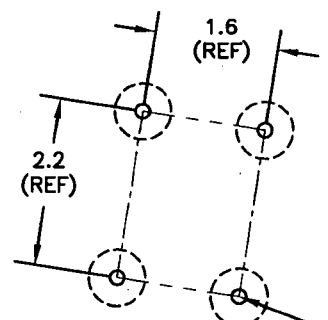
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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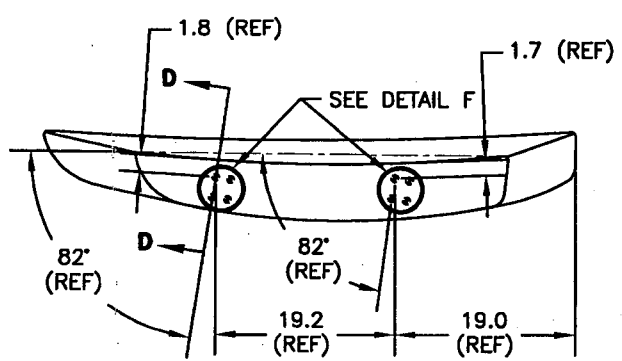
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DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 2 OF 11
		SCALE	NTS	

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07-04-01

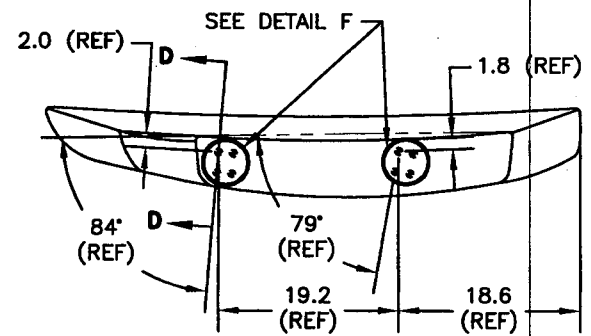


DETAIL F

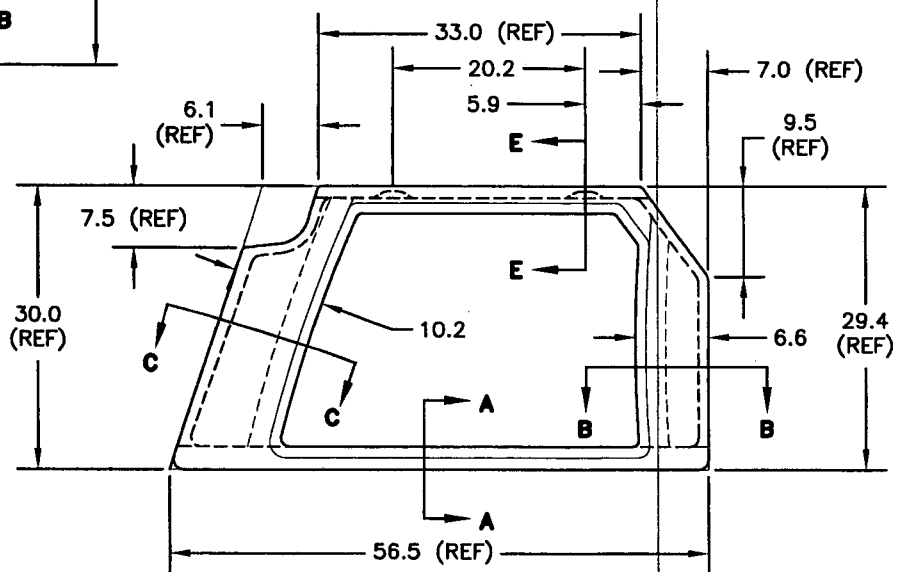
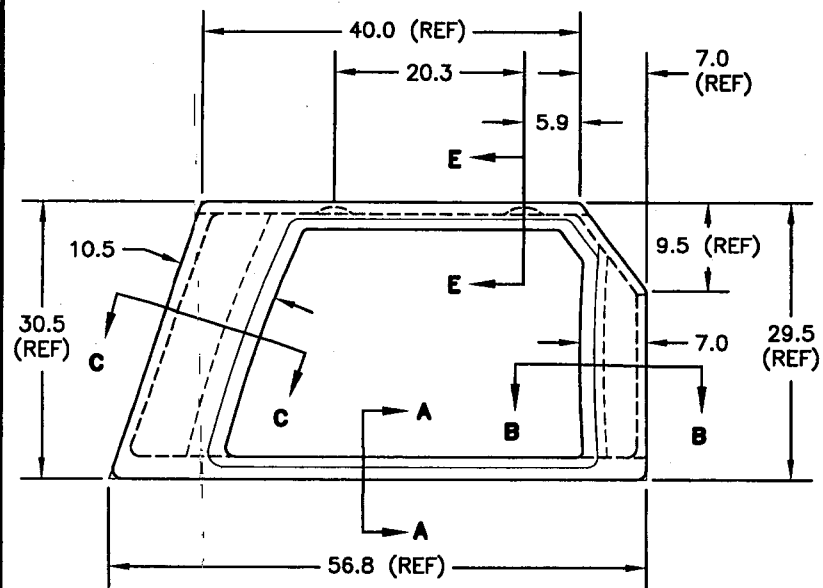
INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



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WORK ORDER
NO. 3181

D3186-1M/-3M NOTES:
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2) SEE SHEET #4 FOR SECTION VIEWS.

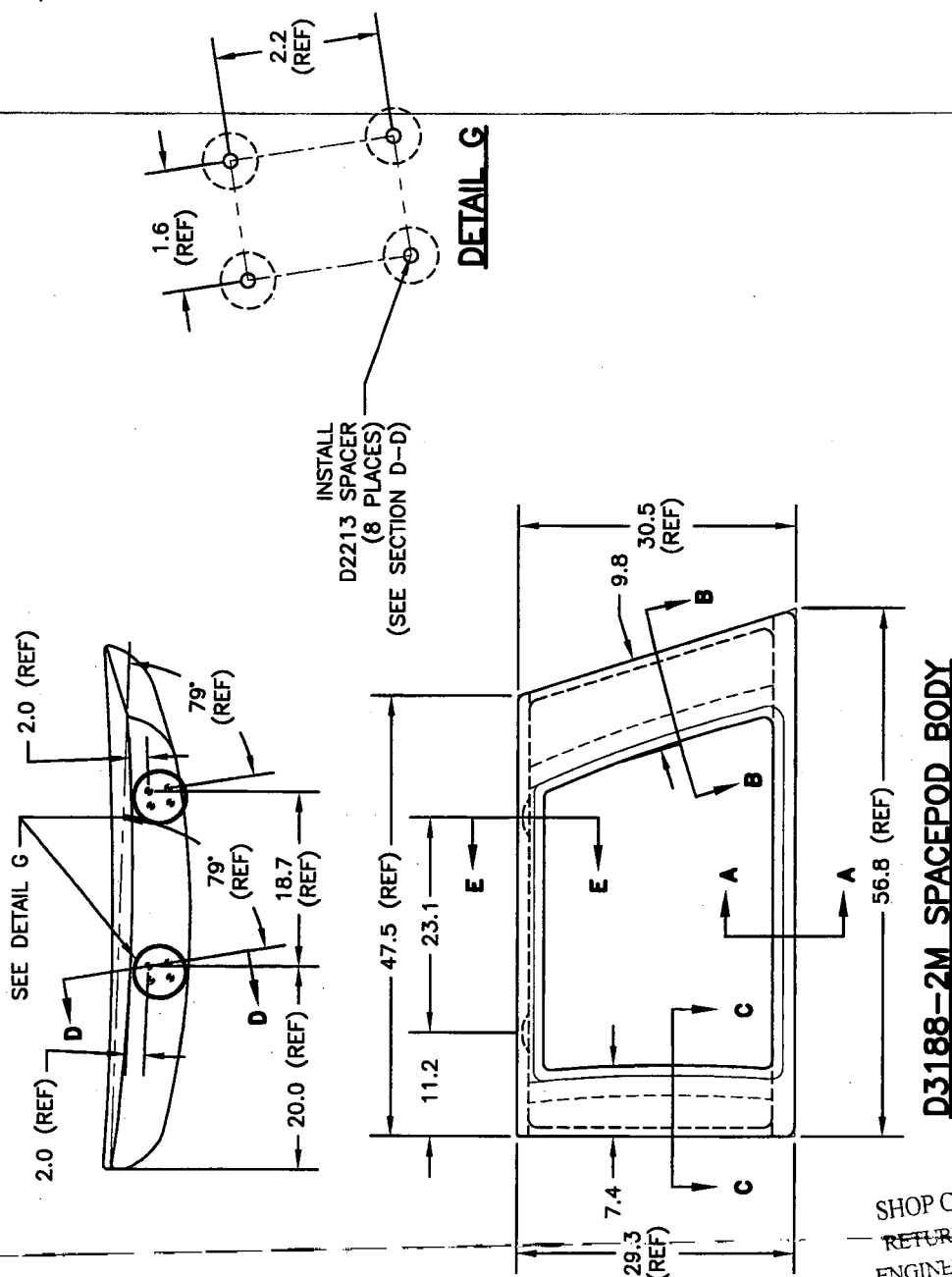
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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07.04.02 [Signature]



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WORK ORDER
31811 [Signature]

D3188-2M NOTES:
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2) SEE SHEET #4 FOR SECTION VIEWS.

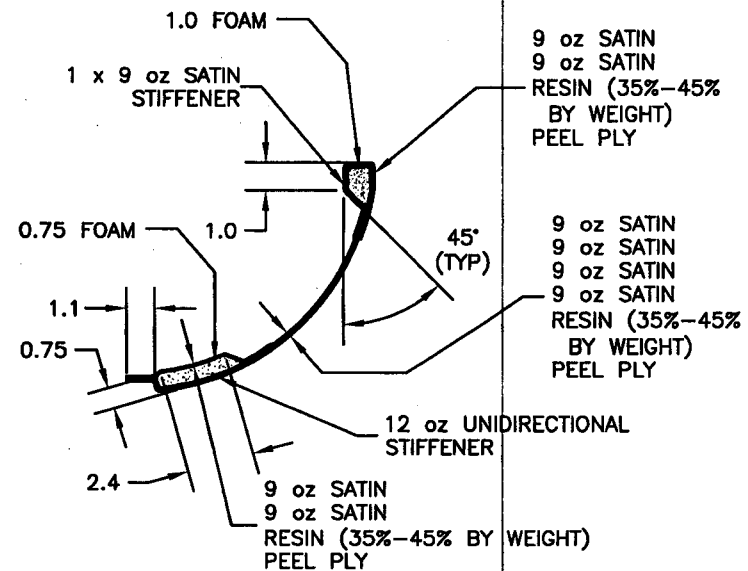
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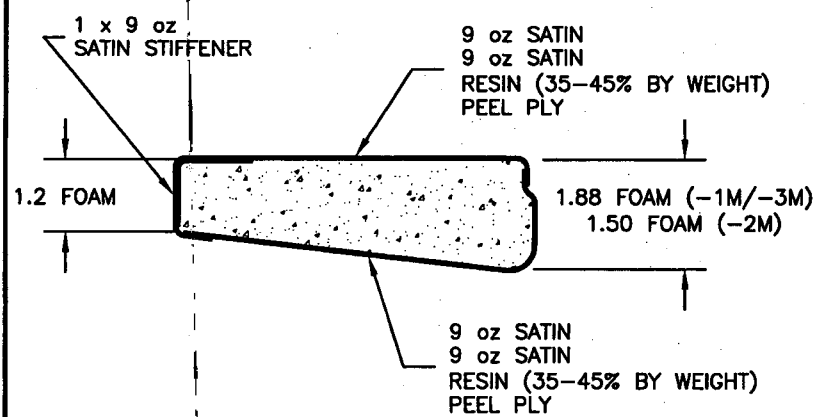
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DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 4 OF 11
		SCALE	NTS	

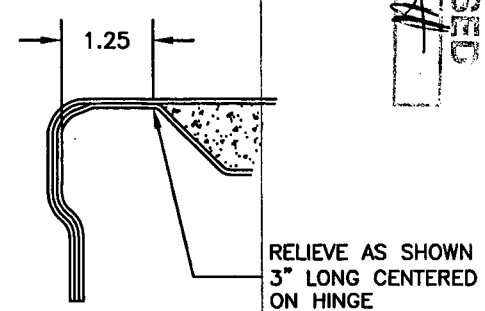
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07.04.01



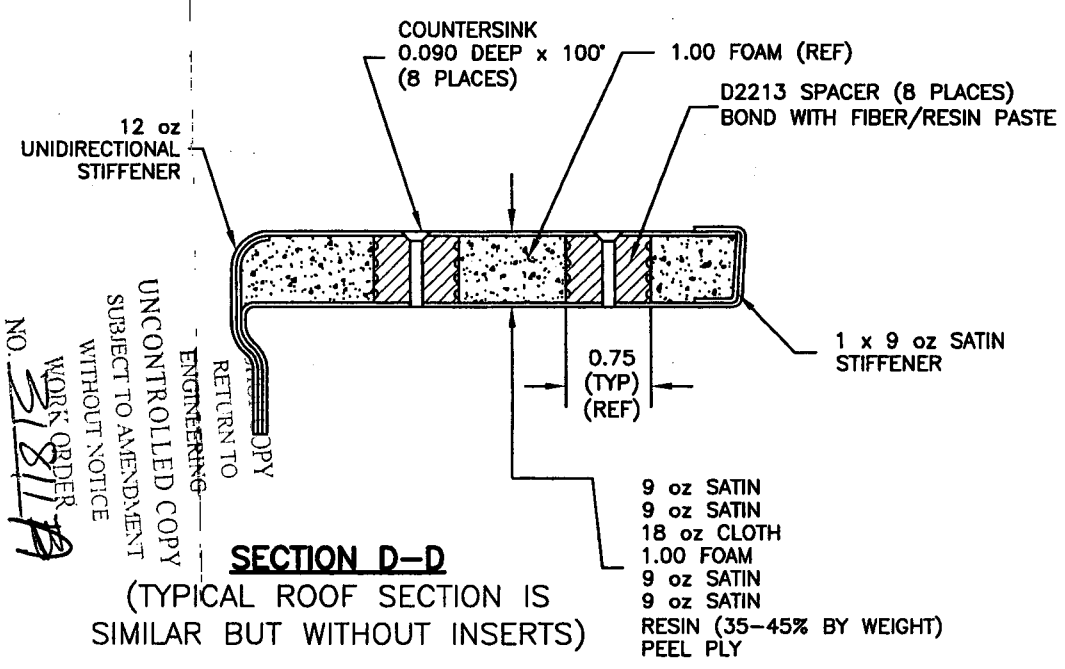
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION E-E
(2 PLACES PER POD)



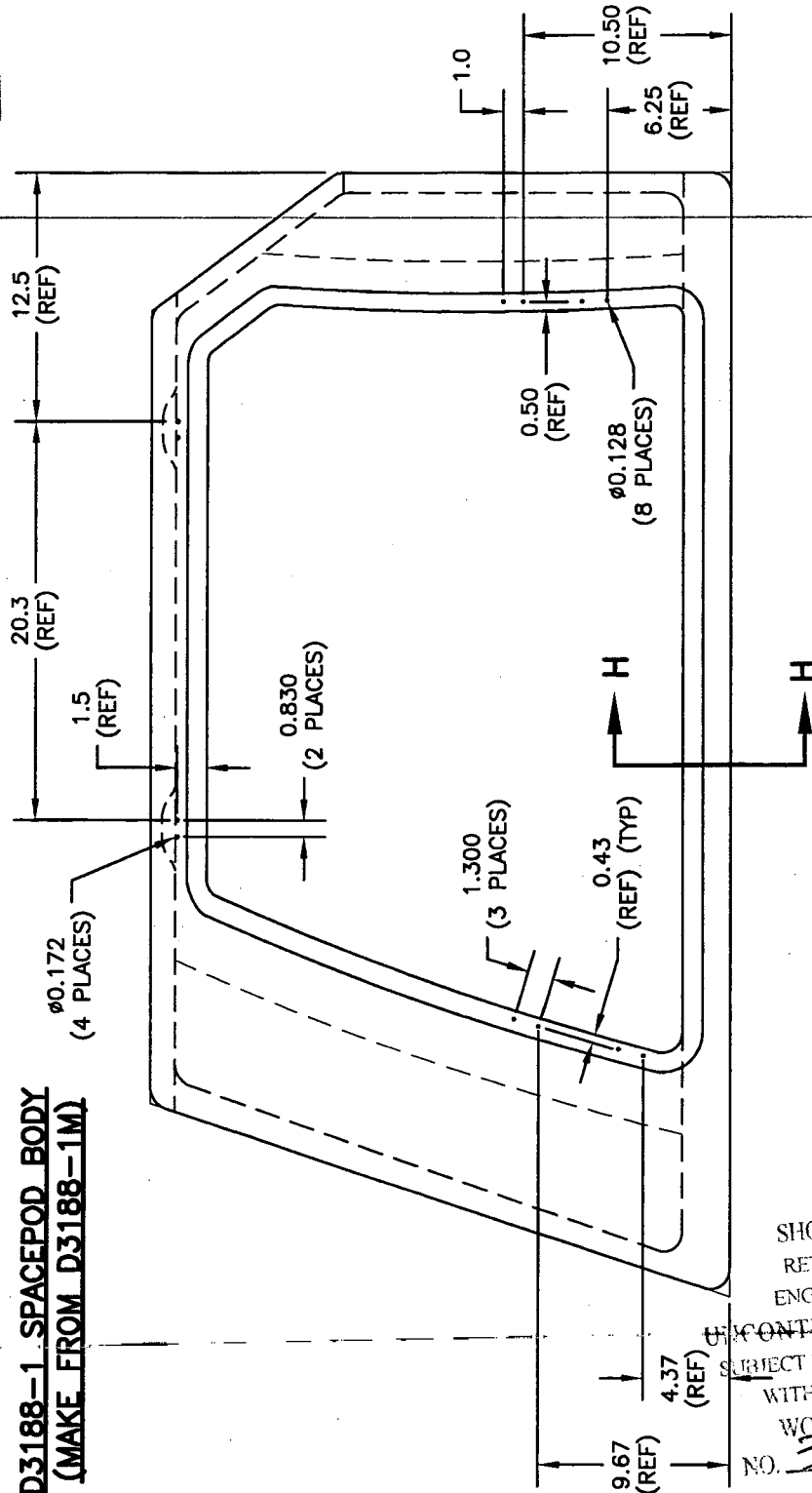
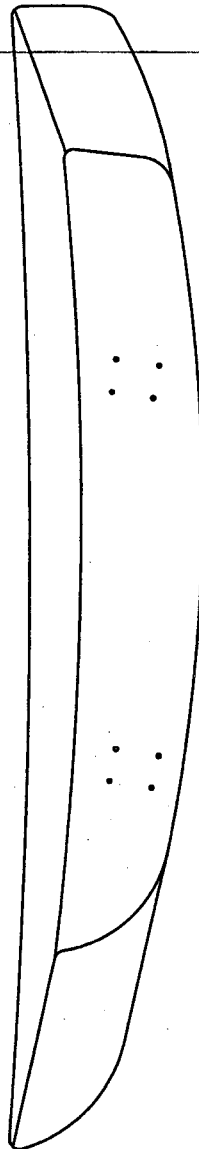
SECTION D-D
(TYPICAL ROOF SECTION IS SIMILAR BUT WITHOUT INSERTS)

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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
07.04.09



D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #111 FOR SECTION VIEW

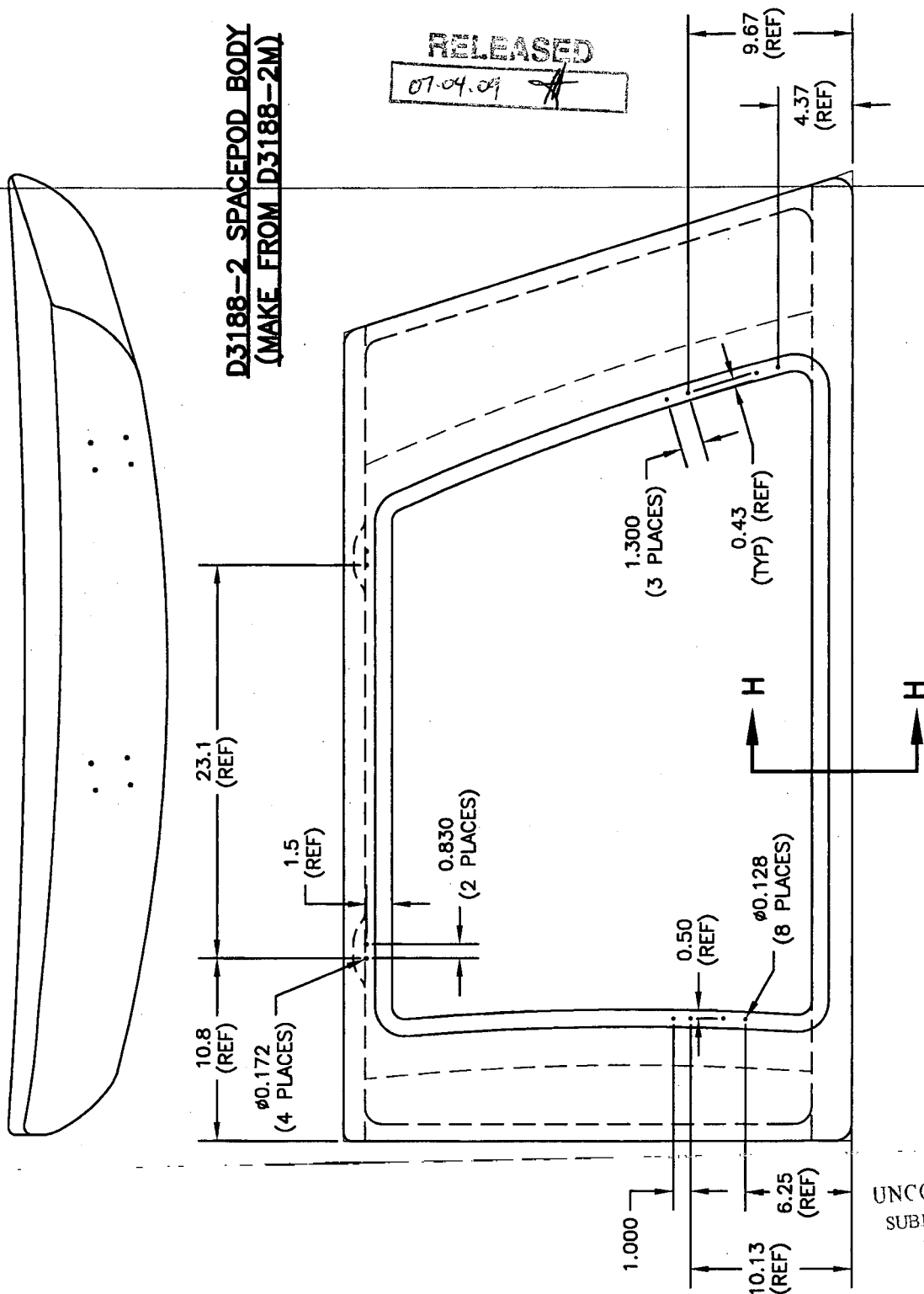
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 6 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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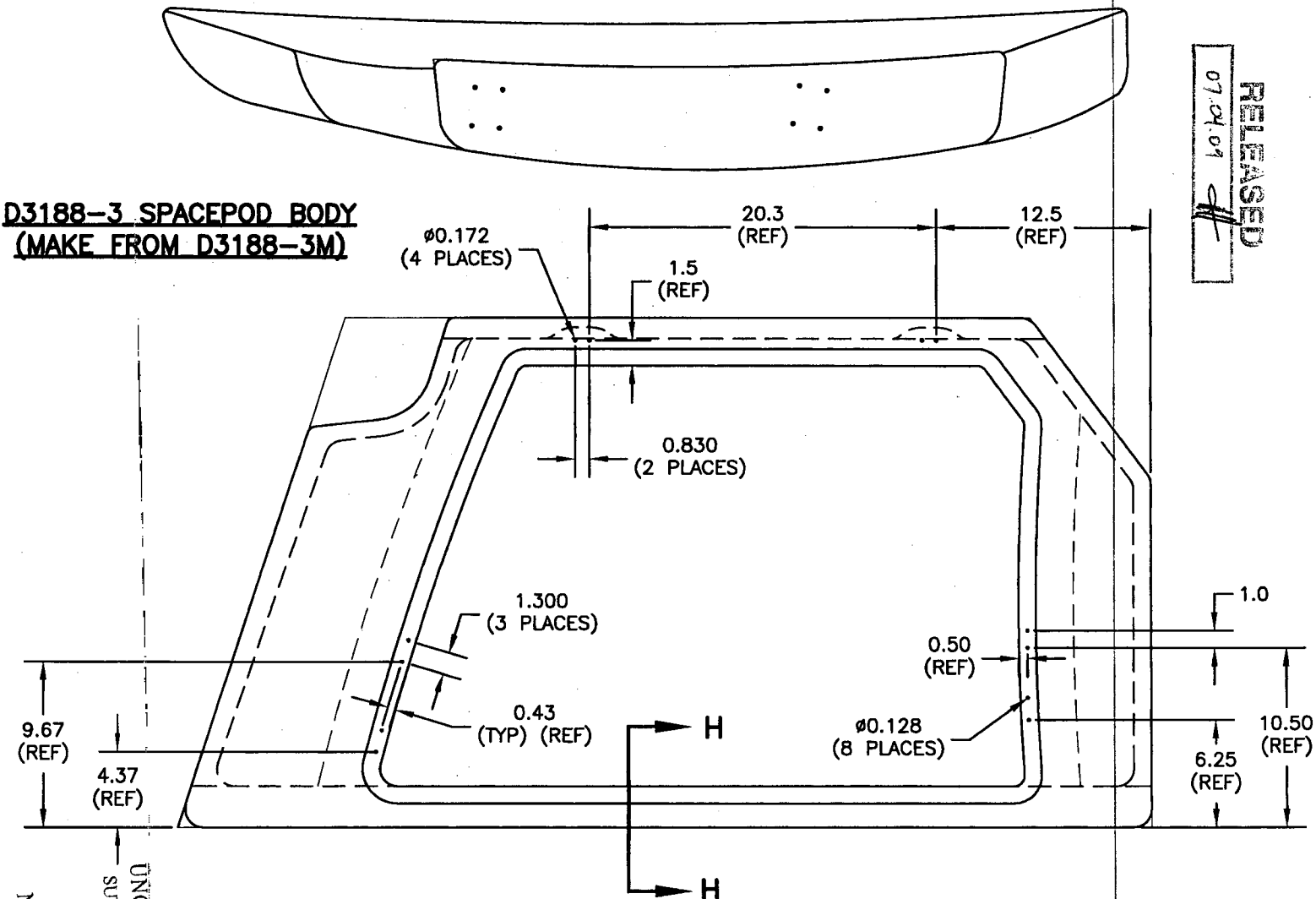
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		D3188	SHEET 7 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY	SCALE NTS	

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07.04.01



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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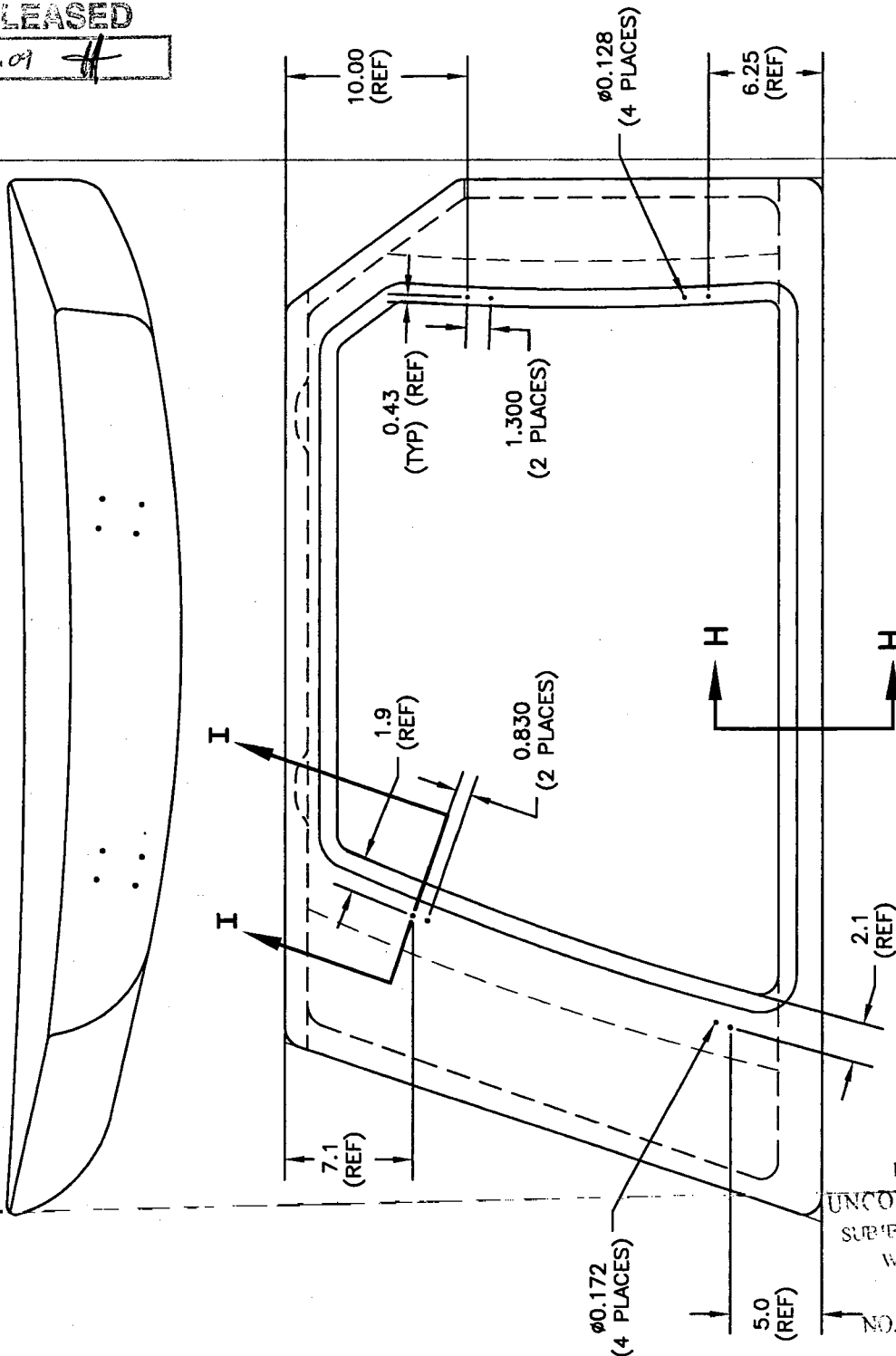


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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.01

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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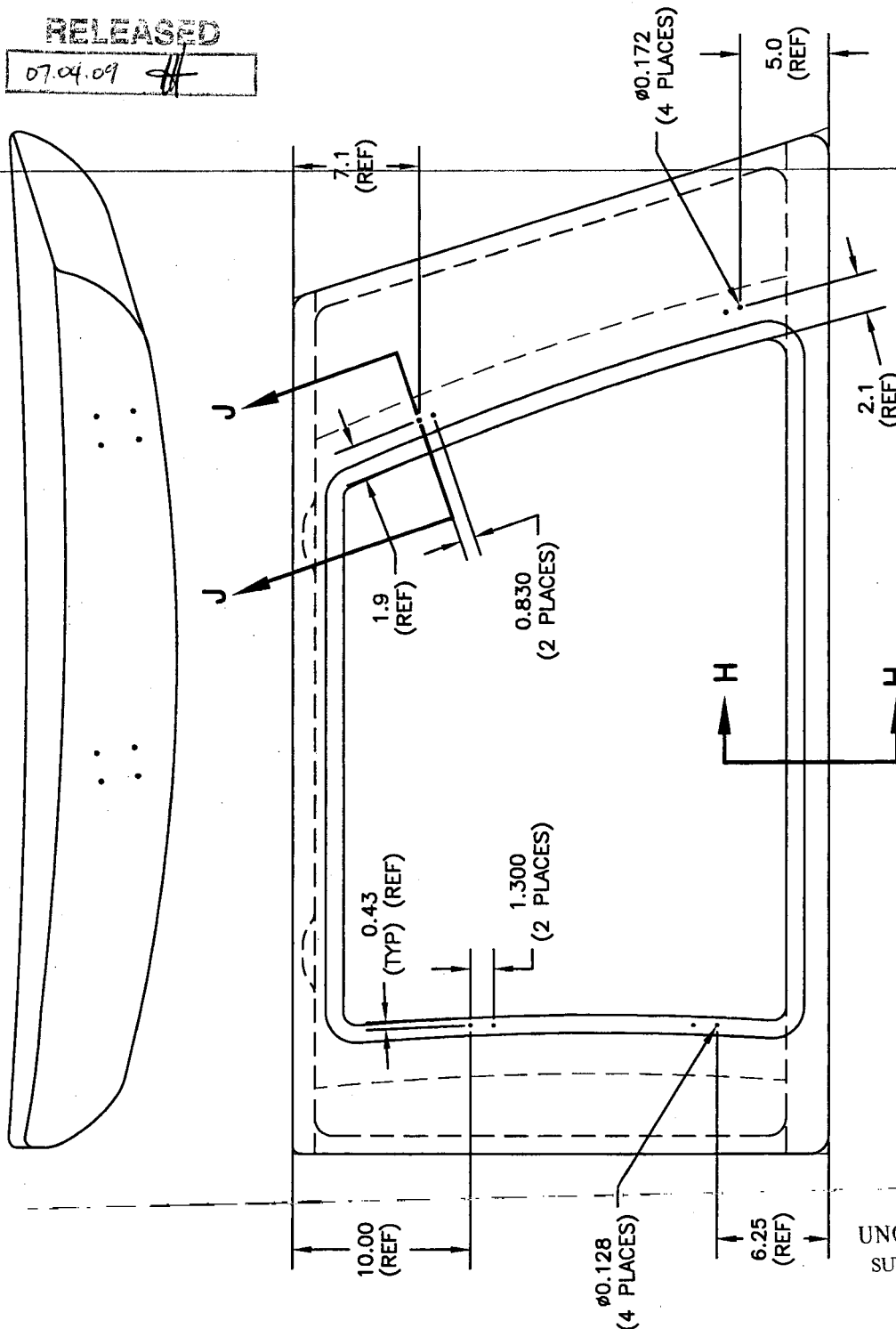


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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.09 #

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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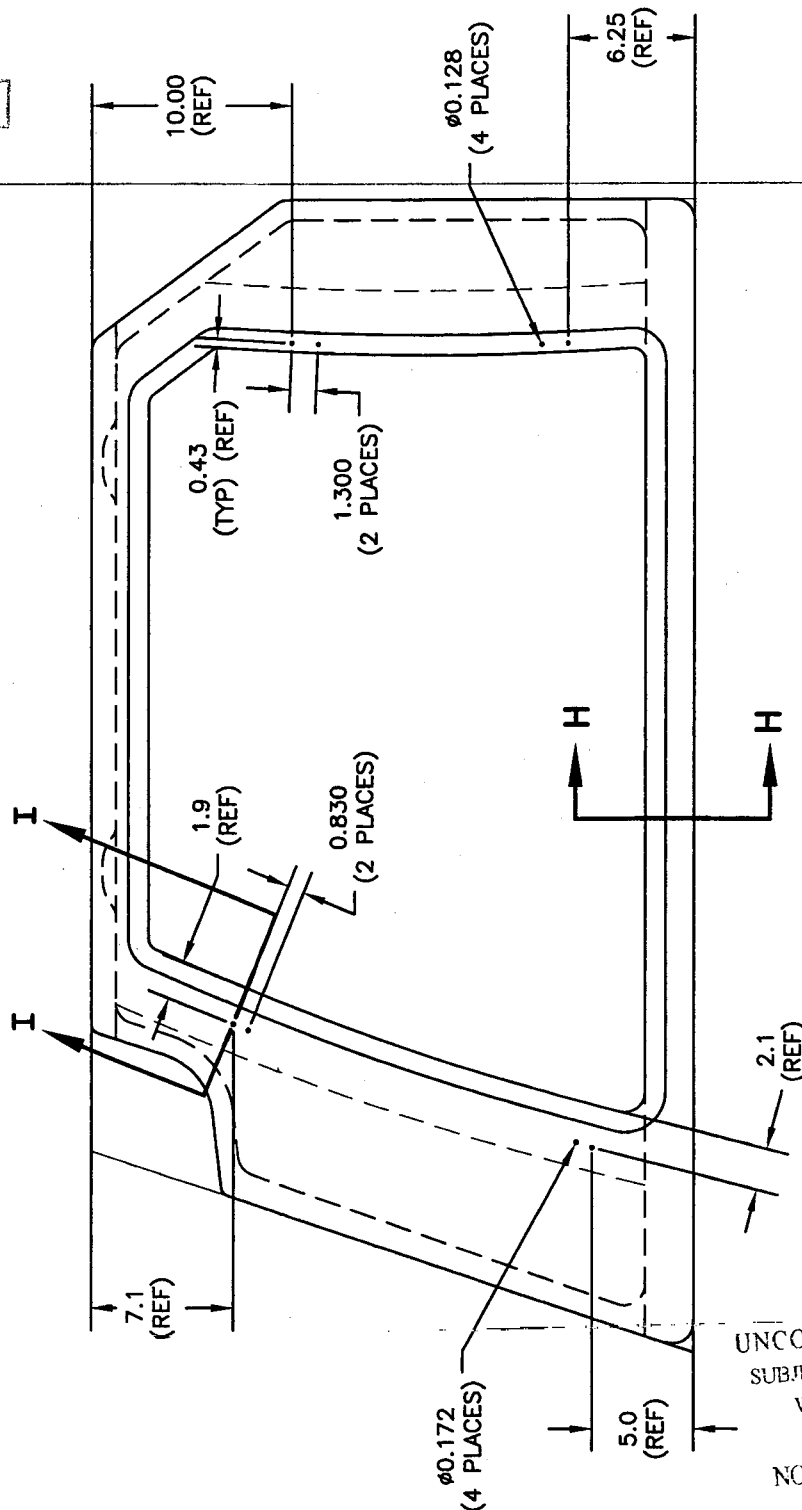
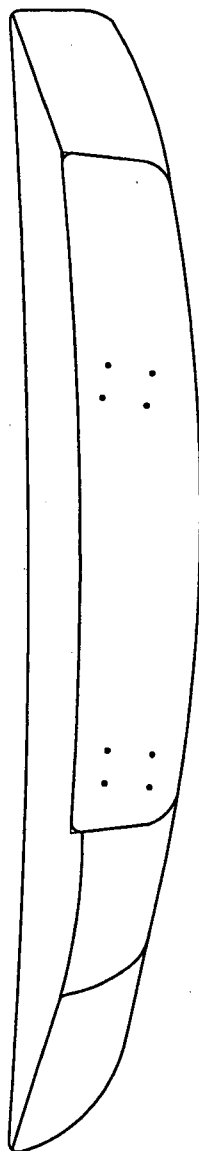
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
07.04.09 **[Signature]**

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 11 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.09

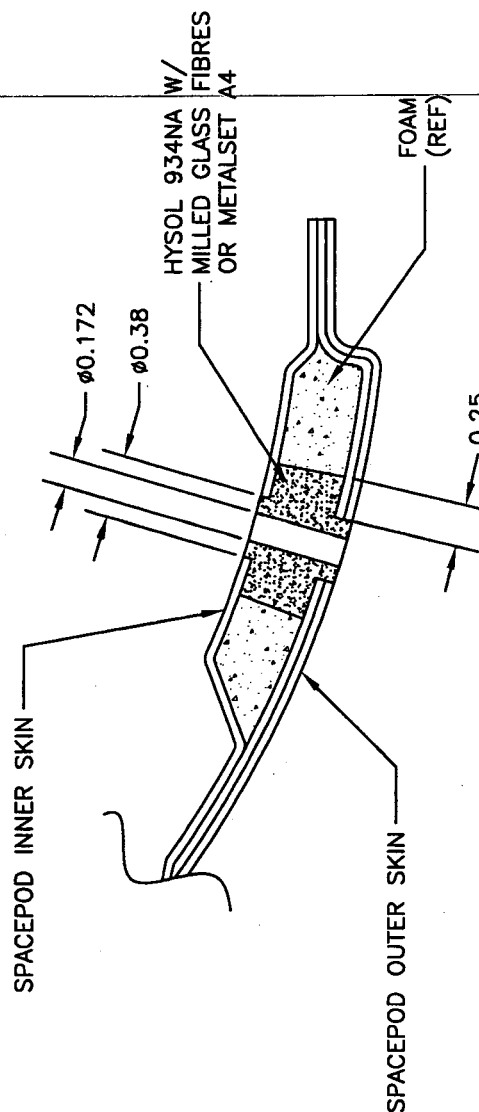
INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H

(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Monday, 4/16/2007 2:32:47 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 31811B01		
Estimate Number	: 12598		
P.O. Number	:	Part Number	: D31861M
This Issue	: 4/16/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 31811C01	Material	:
Written By	:	Due Date	: 4/23/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.04.16</u>		
Comment	: Est Rev: A New Issue 06-12-04 ec est rev D rv D dwg 07.03.07 ec		

Additional Product

Job Number:



W/O 30022

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: _____

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

2.0	D31861P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
 Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins. Ensure surface of
 doo is 'smooth,' no 'dimples' for drilling.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:32:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 31811B01

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 05.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

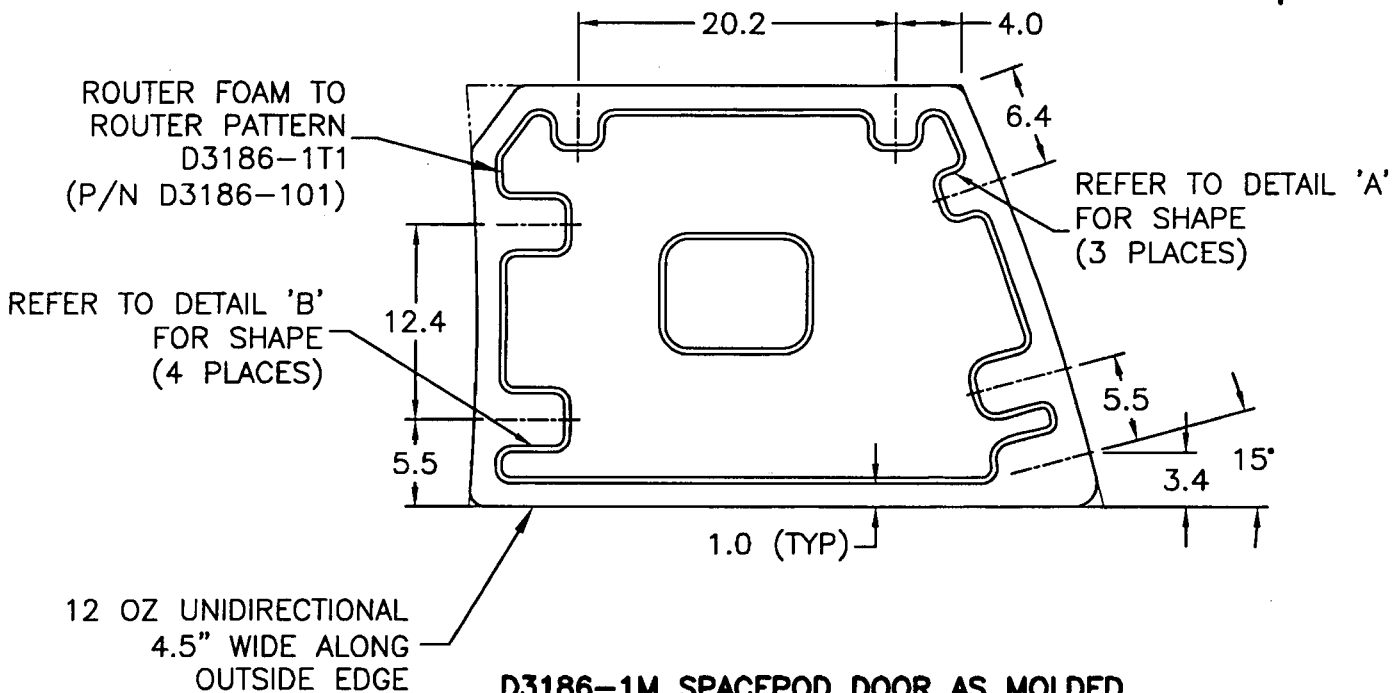
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART_QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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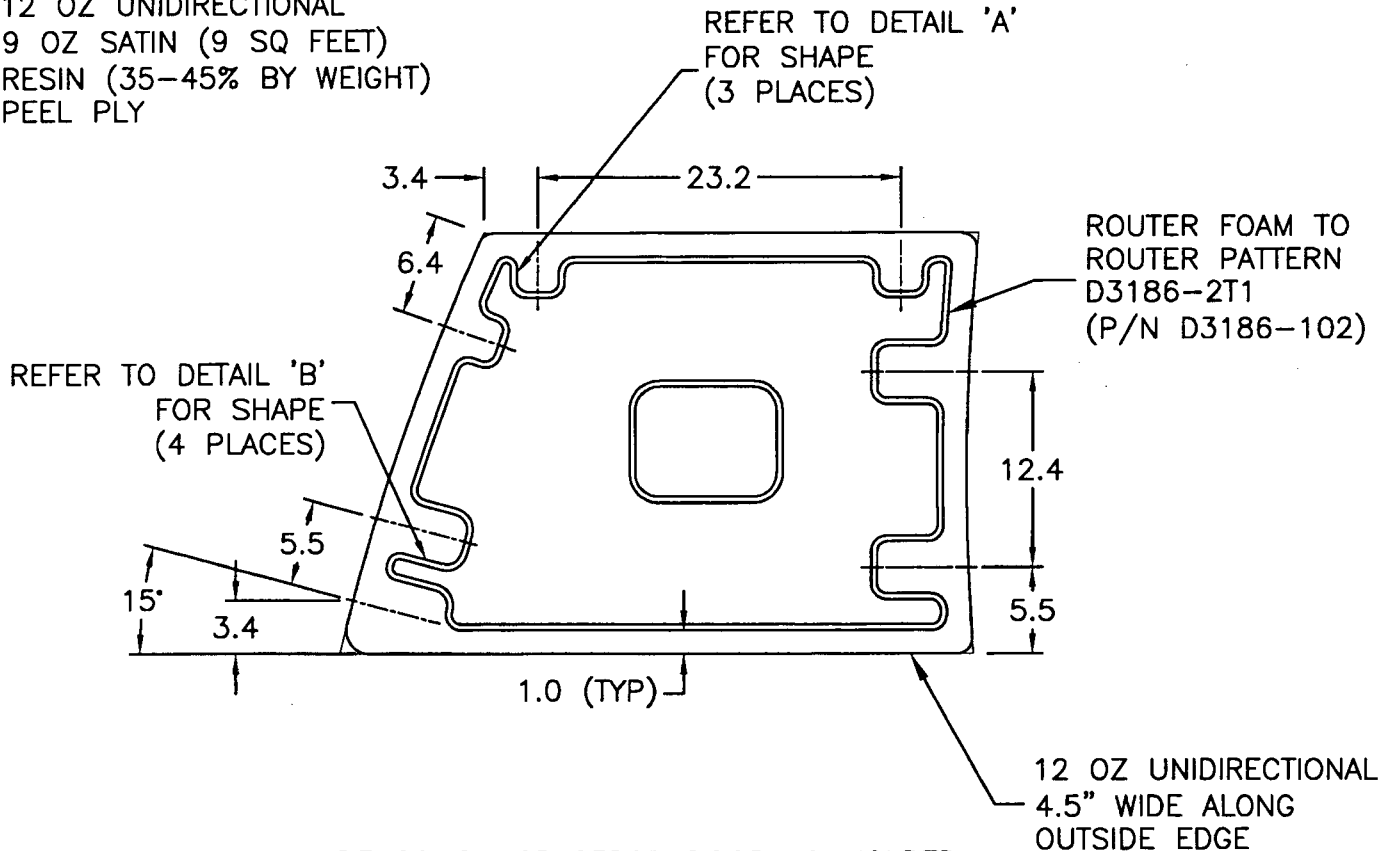
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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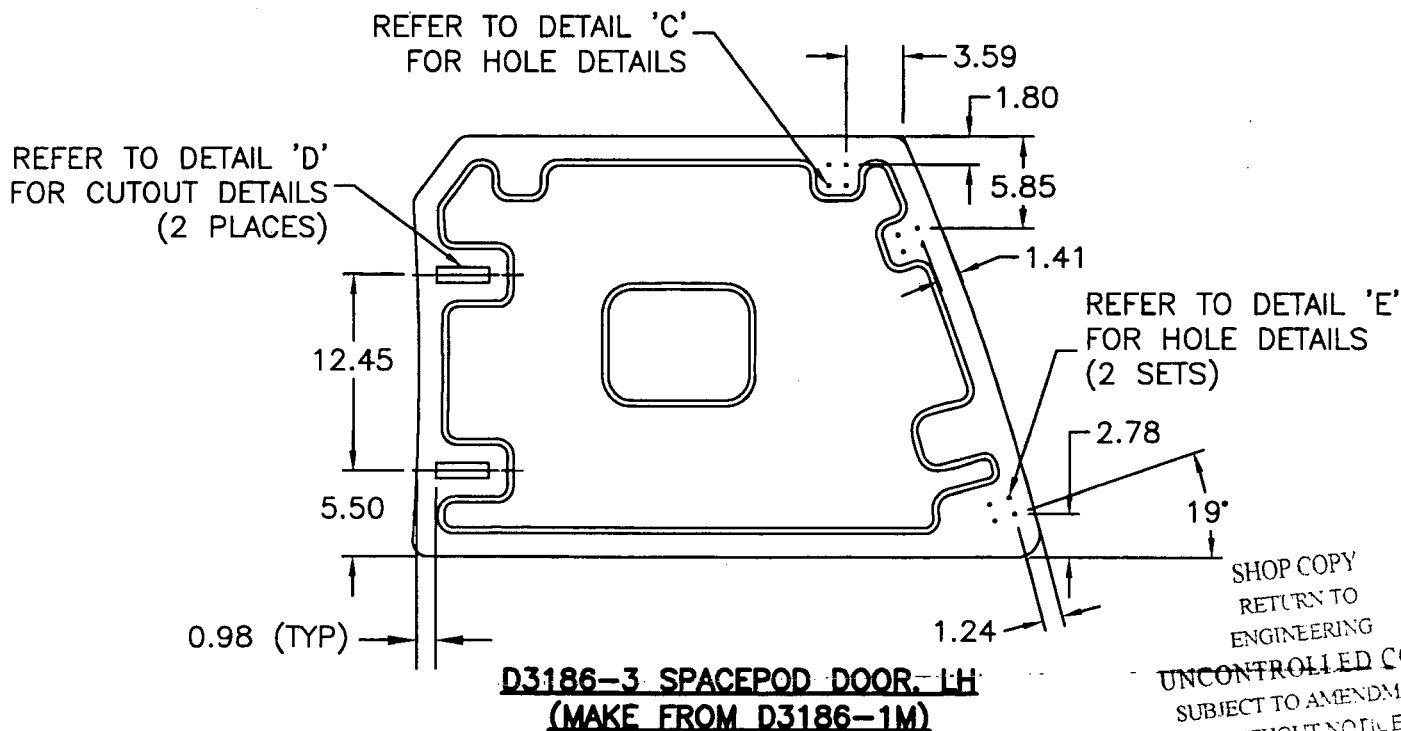
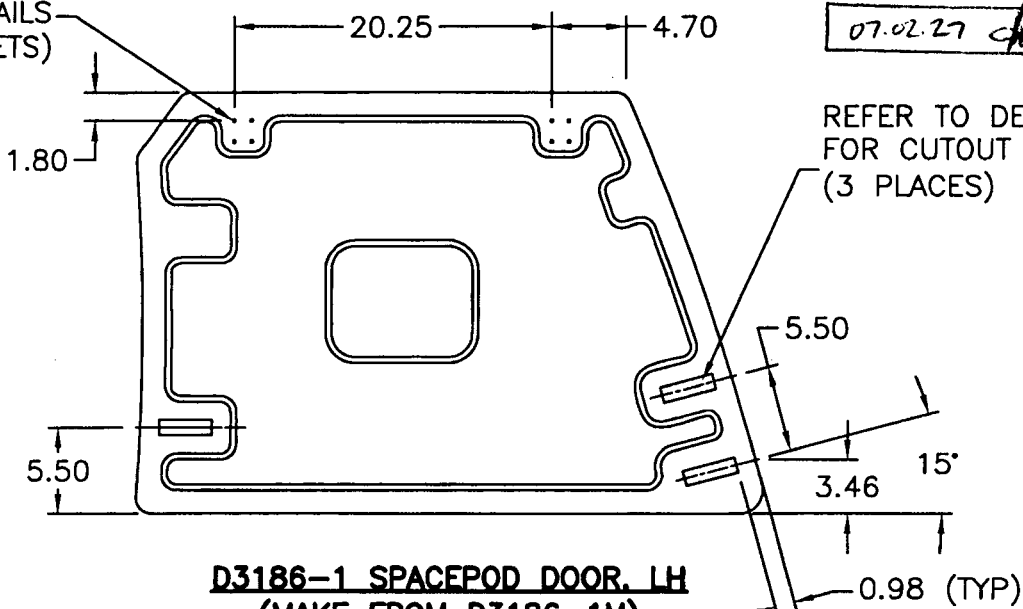
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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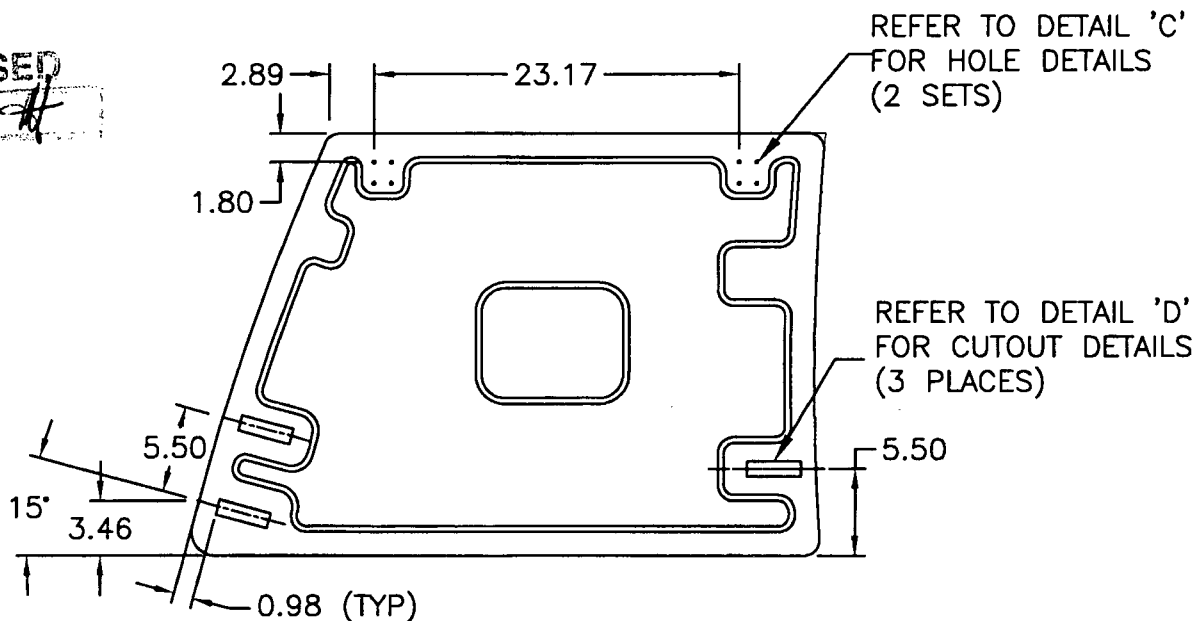
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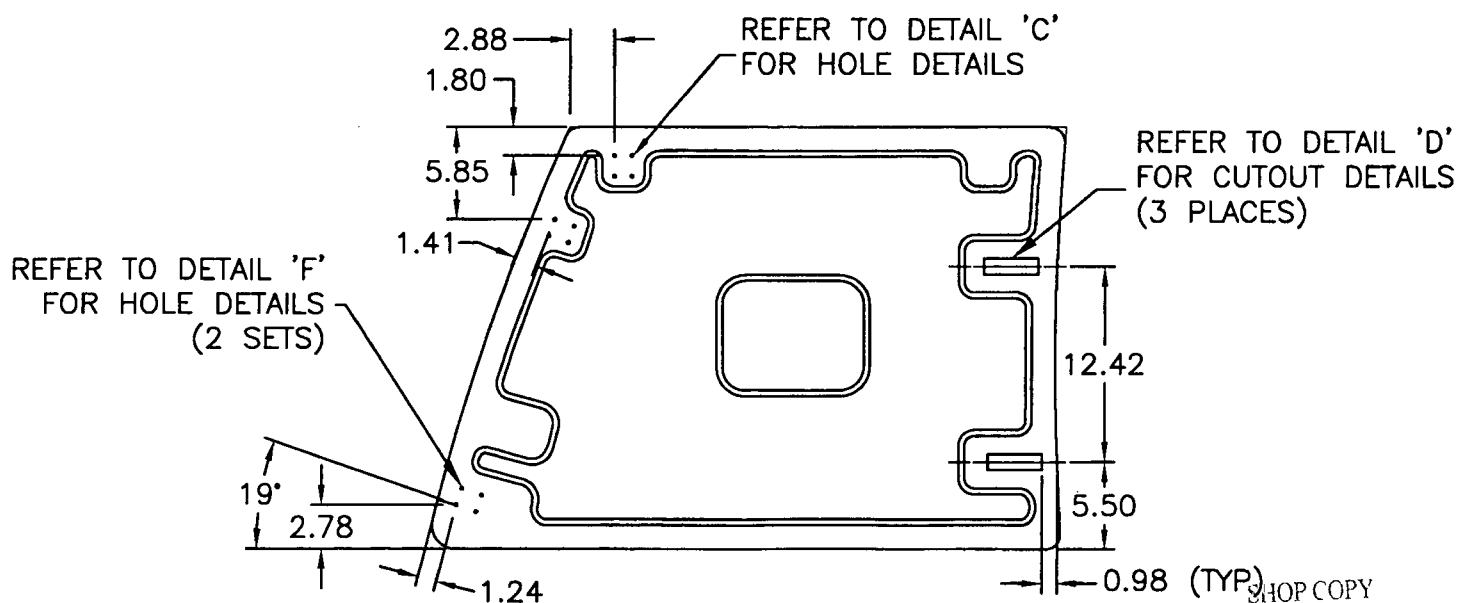


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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
07-02-27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

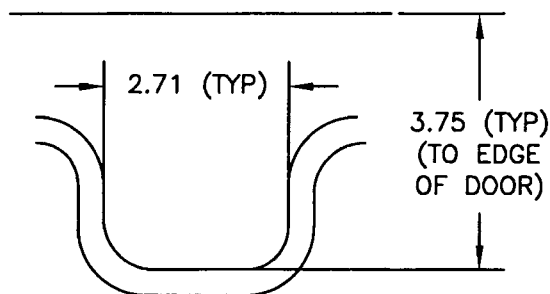
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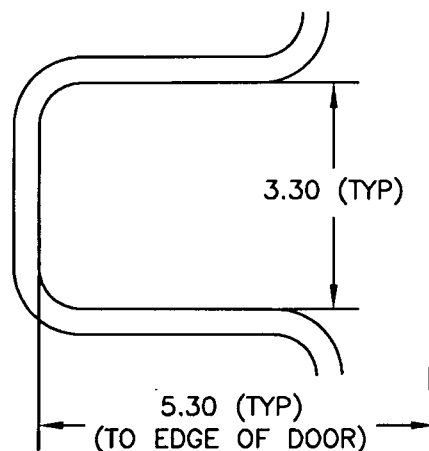
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



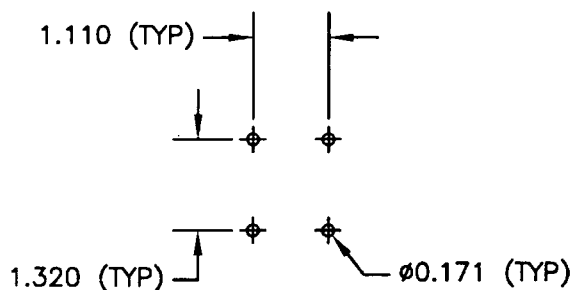
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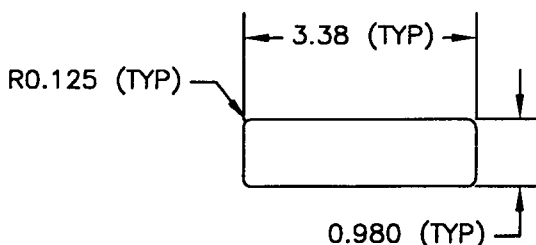
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DETAIL B

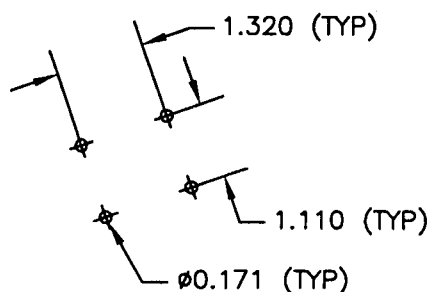


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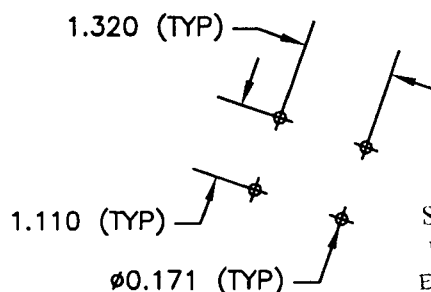


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

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Date: Mardi, 2007-03-06 09:14:56
 Utilisateur: Sylvie Hamel

Feuille de Procédé

Client : DART Dart Aerospace Ltd.	Nom Dessin : SPACEPOD BODY
Numéro Job : 41110	Numéro Article : DKC134-0053
Numéro Soumission : 2585	Numéro Dessin : D3188
Numéro B.A. :	Projet Numéro : DKC134
Cette fois : 2007-03-06 No. B.V. :	Révision dessin : C
Prsht Rev. : NC	Matériel : Fibre 7781 et Résine 411-350
Prem. fois : - - Type :	Date Dûe : 2007-03-09 Qté: 1 UdM: UNITE
Job précédente : 41098	
Écrit par :	
Vérifié & Approuvé par :	
Commentaires : N° de pièce Dart Aerospace : D31881M	

Process Sheet Rev.: 01 Modification générale selon informations de l'ingénierie.

Produit additionnel

W/O 30022

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------


Commentair Qty.: 0.050 UNITE(s)/Unit	Total : 0.050 UNITE(s)
Frekote 44NC	

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min	Total Run : 0.0833Hrs
PRÉPARATION DU MOULE	

Faire la préparation du moule N° DT 8003 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

 Date: 12/04/07 Heure Début: 11:00 Heure Fin: 3:00 Sceau: 

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 9.84 VERGE(s)/Unit	Total : 9.84 VERGE(s)
Tissu à délaminer Release ply B	

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 9.27 VERGE(s)/Unit	Total : 9.27 VERGE(s)
Wrightlon 5200 Bleu P3	

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 6.00 VERGE(s)/Unit	Total : 6.00 VERGE(s)
Feutre de drainage N° Airweave N 10	

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 7.00 VERGE(s)/Unit	Total : 7.00 VERGE(s)
Stretchlon 200 poche à vide Vert	

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41110

Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 11.400 VERGE(s)/Unit Total : 11.400 VERGE(s)
9.7 oz Weave #FG-778150-125Y Volan Finish 1-6030-1

8.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)
Fiberglass 12 oz Unidirectional N° de Lot: 5455

10.0 AAC0633 WR1850 ROVING 18 OZ x 50"

Commentair Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s)
WR1850 ROVING 18 OZ x 50" N° de Lot: 1-5873-1

11.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 8/6/07 Heure Début: 12:30 Heure Fin: 3:00 Sceau: 32

12.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 5921

13.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6086-1

14.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: Mardi, 2007-03-06 09:14:56

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41110

Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Préparer une seringue rempli de 30 ml de résine chargé de fibre dde verre Mia Poxly 66.

Date: 16/04/07 Heure Début: 12:30 Heure Fin: 12:35 Sceau:



16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue. Faire un joint tout autour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8003 et ensuite imbiber un pli de tissu 9.7oz. et un 18 oz. sur la section supérieur de la pièces.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: 16/04/07 Heure Début: 12:35 Heure Fin: 1:15 Sceau:



17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Film Perforé P-3
- 3- Feutre de drainage.
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures Minimum.

Date: 16/04/07 Heure Début: 1:15 Heure fin: 1:35 Sceau:



Curing Début: 1:35 PM Curing Fin: 8:00 AM

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total: 0.75 FEUILLE(s)

ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3-5915-2

Date: Mardi, 2007-03-06 09:14:56
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41110

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

19.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs
TAILLAGE DU MATÉRIEL

Tailler et le Foam Core 1" selon plan de découpe et gabarits

Date: 17/04/07 Heure Début: 10:15 Heure Fin: 12:00 Sceau:

20.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6086-1

21.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

22.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Prendre les deux pièces de 11" x 57" et sceller 1 grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.

17/04/07



23.0 AAC0452 Polybond B46F

Commentaire Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)
Polybond B46F

N° de Lot: 5979

24.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

À l'aide de polybond, coller ensemble les deux surfaces scellées

Disposer des poids sur les pièces pour conserver une pression de collage.

Laisser sécher 2 heures minimum.

Quantité: 1 Date: 17/04/07 Sceau:



Date: Mardi, 2007-03-06 09:14:56
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41110

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

Quantité: Date: Sceau:

25.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin.

Quantité: 1 Date: 17/04/07 Sceau: 

Quantité: Date: Sceau:

26.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6086-1

27.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

28.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
PRÉPARATION DU MATÉRIEL DART

18/04/07



Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 promu 75 minutes..

29.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
FABRICATION GÉNÉRALE DART

-Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu 75 minutes. Selon I.G. # Sceller le Foam Core

Laisser sécher pendant 2 heures minimum.

Date: 18/04/07 Sceau:   Initiales:

Date: Mardi, 2007-03-06 09:14:56
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41110

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

30.0 AAC0452 Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)
Polybond B46F N° de Lot: 5979

31.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du Polybond.

Date: 19/04/07 Heure Début: 10:15 Heure Fin: 10:25 Sceau:

32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: 19/04/07 Heure Début: 11:00 Heure Fin: 11:30 Sceau:

33.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé

Date: 19/04/07 Heure Début: 11:30 Heure Fin: 11:50 Sceau:

Curing Début: 11:00 Curing Fin: 12:00

34.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6079-1

Date: Mardi, 2007-03-06 09:14:56

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41110

Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

35.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

36.0 FINITION 3 FINITION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plos gros défauts, utiliser du polybond.

Date: 20/04/07 Heure Début: 1:00 Heure Fin: 3:00 Sceau:



37.0 TRIMAGE 3 TRIMAGE COMPOSITES DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.



38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6105-1

39.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

40.0 FINITION 3 FINITION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le fom Core

Laisser sécher pendant 2 heures minimum.

Quantité: / Date: APR 23 2007 Sceau:



Quantité: Date: Sceau:

Date: Mardi, 2007-03-06 09:14:56

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41110

Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

41.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5921

42.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6105-1

43.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: APR 2 3 2007 Heure Début: 12:45 Heure Fin: 12:50 Sceau:



44.0 LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: APR 2 3 2007 Heure Début: 12:50 Heure Fin: 1:40 Sceau:



45.0 POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: Mardi, 2007-03-06 09:14:56

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41110

Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description:

Date: APR 23 2007

Heure Début: 1:40

Heure Fin: 2:00

Sceau:



Curing Début: 12:50

Curing Fin:

46.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

DÉMOULAGE DES PIECES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: APR 24 2007

Heure Début: 10:15

Heure Fin: 11:00

Sceau:



47.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit de N° DT5801.

Par l'intérieur, percer les 8 dégagement de ø .745" pour les spacers. (Ne pas percer la peau extérieur de la pièce)

Date: 24/04/07

Heure Début: 10:25

Heure Fin: 10:55

Sceau:



48.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5921

49.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6105-1

50.0

AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

Date: Mardi, 2007-03-06 09:14:56
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41110

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération:

Description :

51.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

APR 24 2007

Date: Heure Début: 3:50 Heure Fin: 3:55 Sceau:



52.0

AAC0448

Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s)

Spacer N° D2213

N° de Lot:

1-5949-1

53.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre Miapoxy 66

Laminer une pièce de 9 oz. sur chacune des 2 zones de 4 spacers.pour reboucher les trous.

Appliquer un pression sur les pièces.de 9 oz. à l'aide d'un.bloc de bois et de pinces autobloquantes.

Laisser sécher pendant 4 heures minimum.

APR 24 2007

Date: Heure Début: 3:55 Heure Fin: 4:25 Sceau:



Curing Début: 3:55 PM Curing Fin: 8:00 AM

54.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot:

5921

55.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6105-1

Date: Mardi, 2007-03-06 09:14:56

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41110Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

56.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: APR 25 2007

Heure Début: 11:00

Heure Fin: 11:05

Sceau:



57.0 LAMINAGE. LAMINAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et les blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièce selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: APR 25 2007

Heure Début: 11:05

Heure Fin: 11:45

Sceau:



Curing Début: 16:05

Curing Fin: 8:00

58.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

② Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.

① Percer les 8 trous des spacers afin de les déboucher.

① Quantité: 1 Date: 26/04/07

Sceau:



② Quantité: 1 Date: 30-4-07

Sceau:



59.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)
Dupont Primer N° 1104S

Date: Merdi, 2007-03-06 09:14:57

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41110

Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

60.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)
Dupont Activator N° 7975S

61.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)
Dupont Reducer N° 12375S

62.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

APR 3 0 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

63.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer le primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. Application de primer.

Laisser sécher 3 heures minimum.

APR 3 0 2007

Date: Heure Début: Heure Fin: Sceau:



64.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6044-1

65.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

66.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide de Sikkens

Faire un léger sablage (grit 220) de toutes les surfaces.

Date: 05/07 Heure Début: 12:40 Heure Fin: 4:10 Sceau:



Date: Mardi, 2007-03-06 09:14:57

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41110Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

67.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.2500 GALLON(s)/Unit Total: 0.2500 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-6065-2

68.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.5000 PINTE(s)/Unit Total: 0.5000 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-6065-1

69.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total: 0.0625 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5692-2

70.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Nettoyages Qty 1 02-05-07

/ X

MAY 02 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

71.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs
APPLICATION DE PRIMER

Appliquer deux couches de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les deux couches.

Laisser sécher pendant un minimum de 3 heures.

MAY 02 2007

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____



72.0 INSPECTION 3 INSPECTION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs
INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 03-05-07

Sceau: _____



Initiales: _____

Emballage Qt 1

3/5/07



Date: Wednesday, 12/20/2006 1:44:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 30012		
Estimate Number	: 12598		
P.O. Number	: <i>N/A</i>	Part Number	: D31861M
This Issue	: 12/20/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3186 REV <i>BC</i> <i>LE</i> 07.01.18
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision	: <i>BC</i> <i>LE</i> 07.01.18
Previous Run	: 30011	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 1/21/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i> 061220		
Comment	: Est Rev A New Issue 06-12-04 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *2767*

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

*C 206112121**(1)*

2.0	D31861P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
 Delastek is attached.

LC 7/07/9

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins.

ml 07/05/09

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: *GA*

ml 07/05/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:44:27 PM
By: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 30012

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
19 07/05/17

Job Completion



U 07/05/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

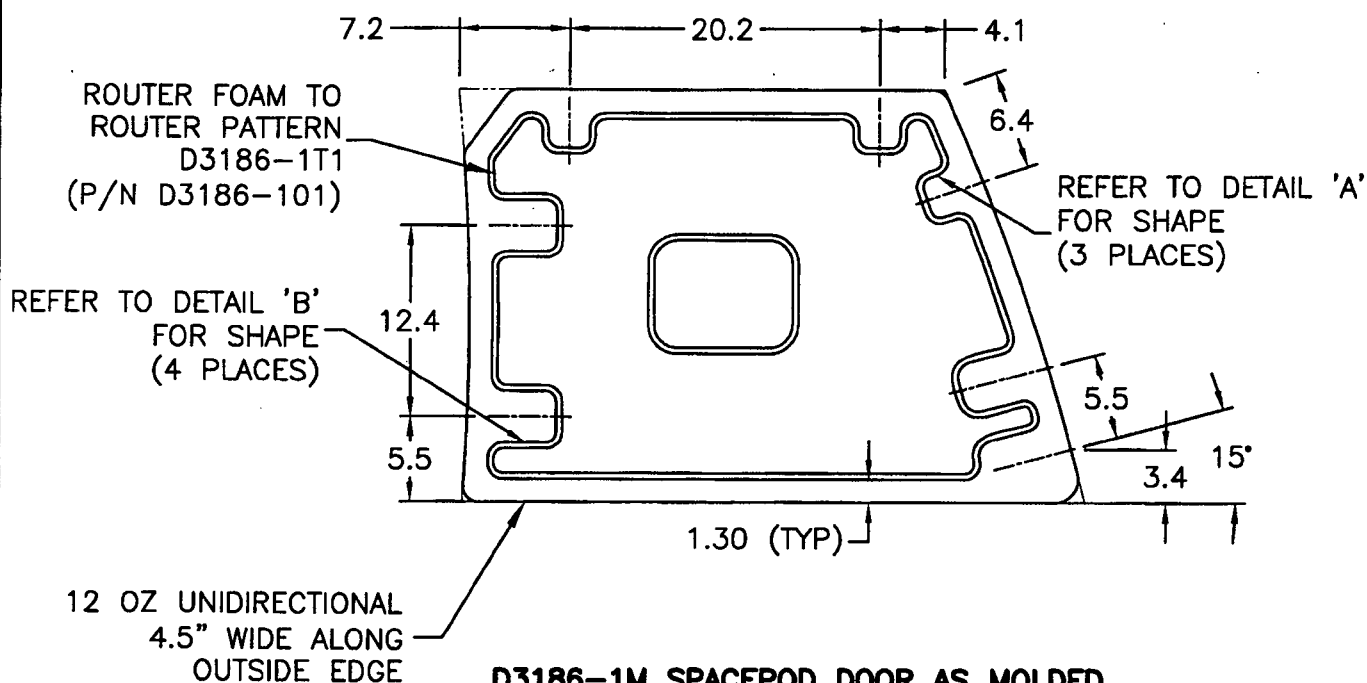
NOTE: Date & initial all entries



DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



D3186-1M SPACEPOD DOOR AS MOLDED

RELEASED
06.12.22

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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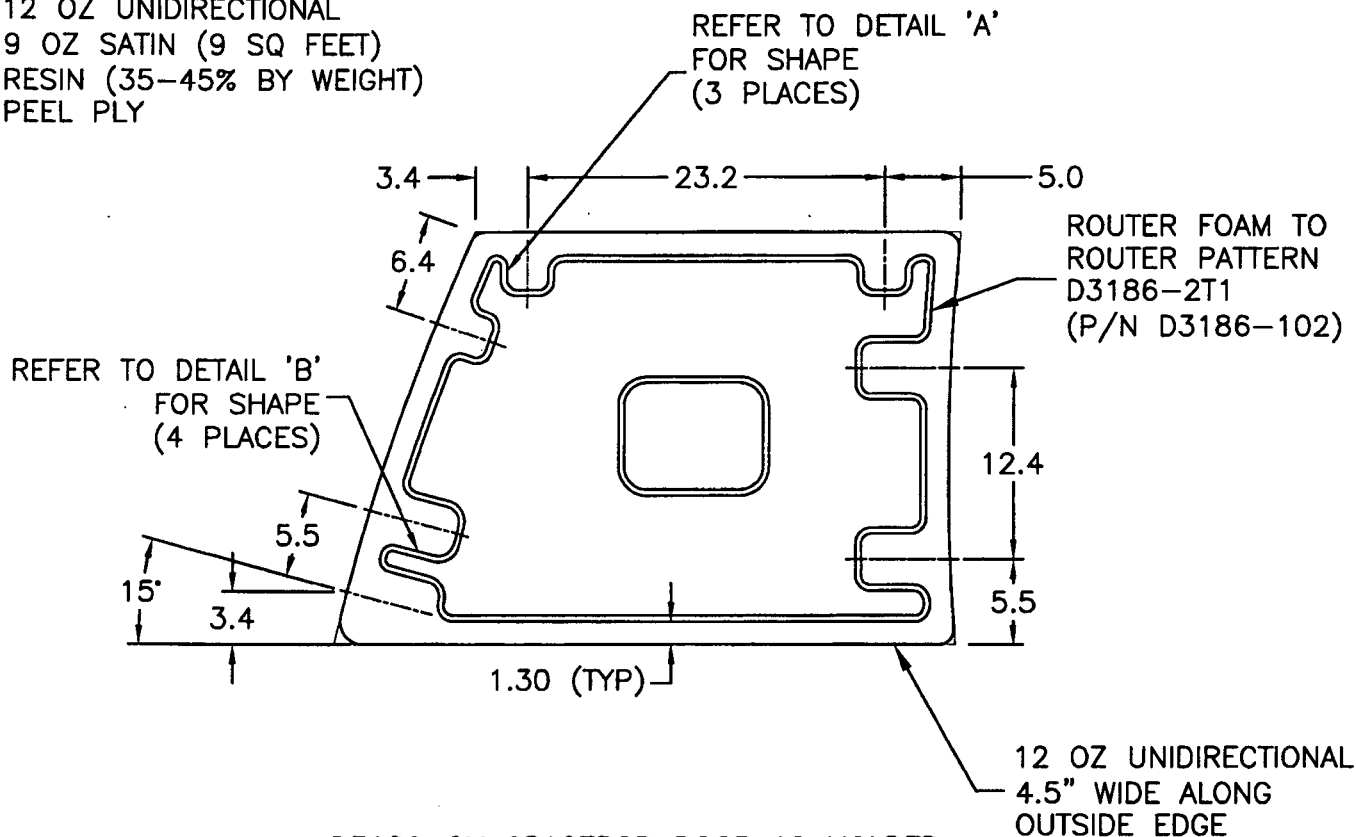
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DART

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CHECKED PH	APPROVED #	DRAWING NO. D3186	REV. C SHEET 2 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED
06.12.13**D3186-2M SPACEPOD DOOR AS MOLDED**NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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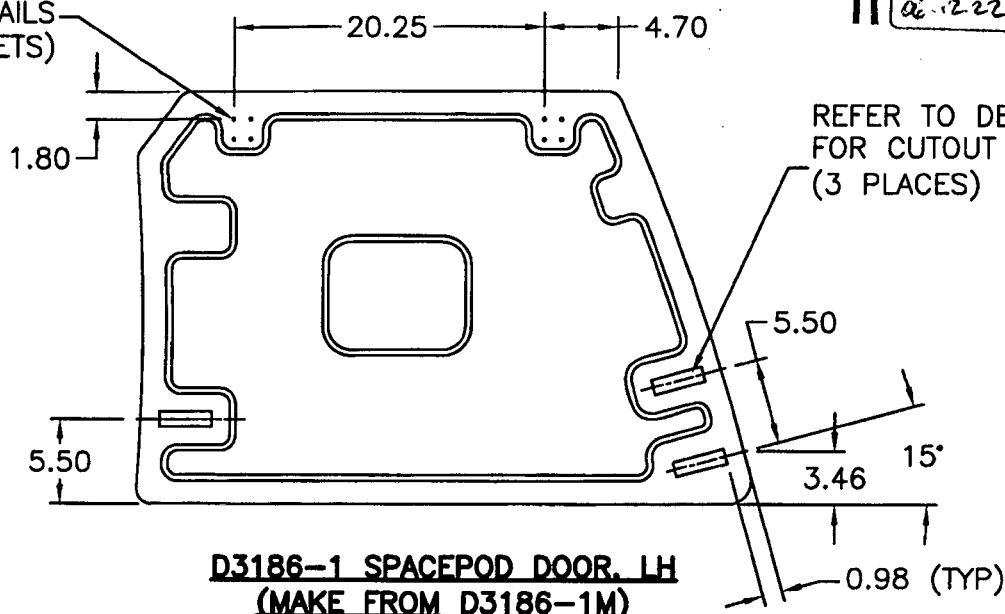
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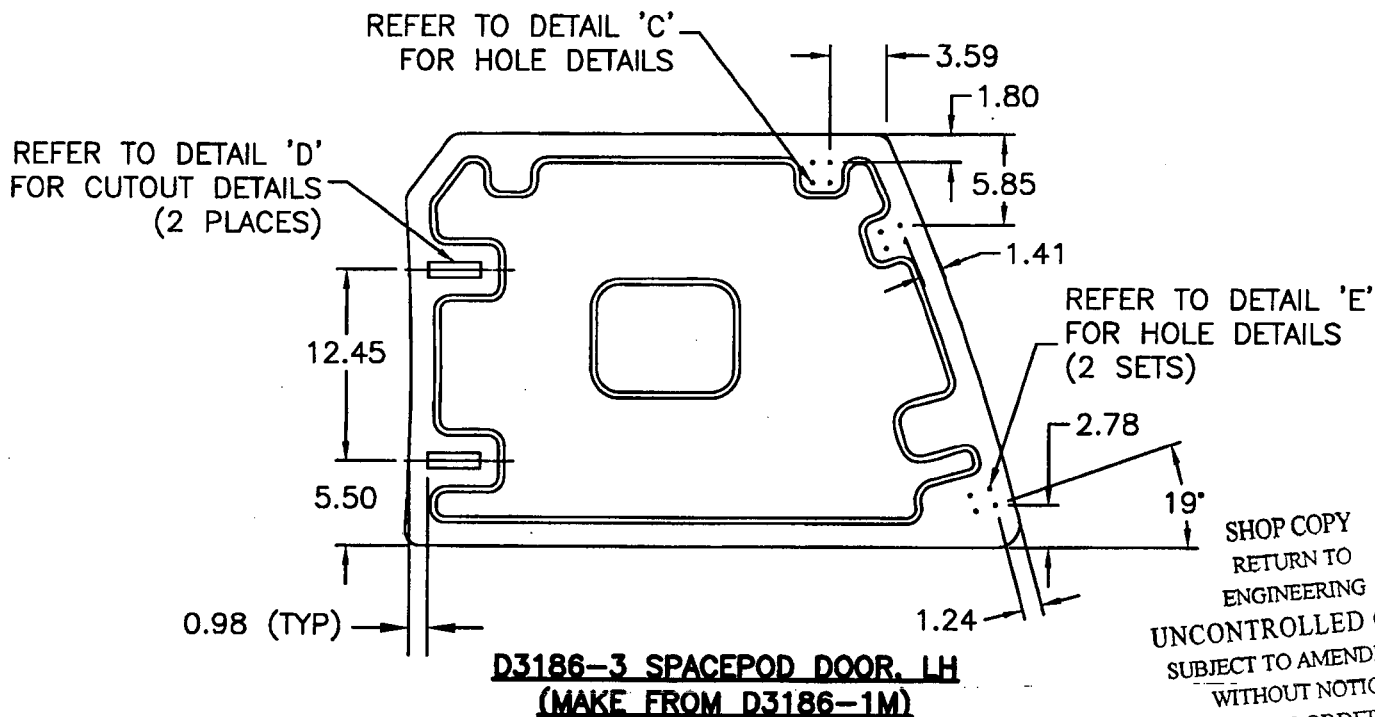


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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



RELEASED
06.12.22 [Signature]



NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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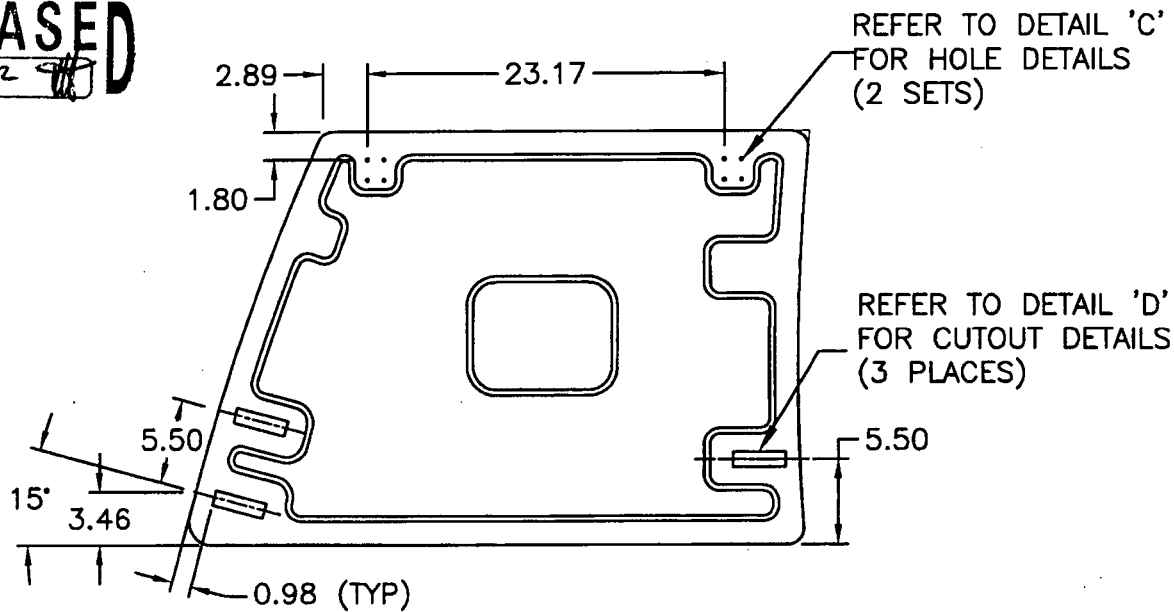
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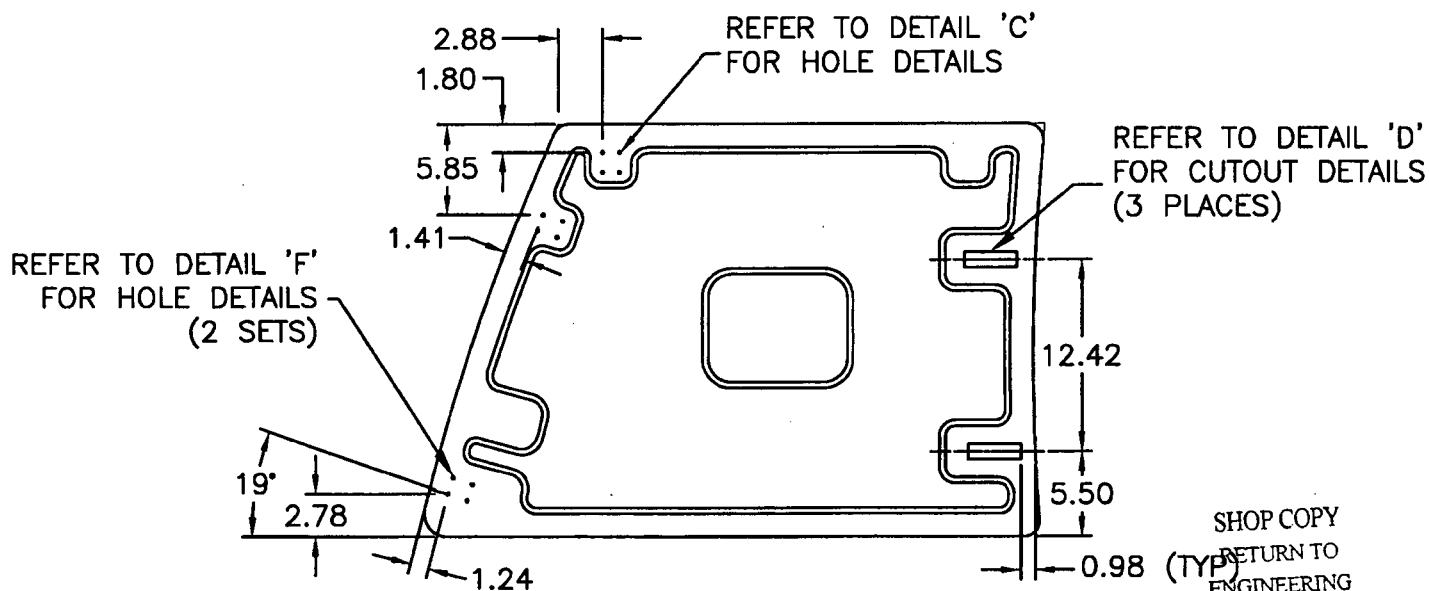


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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
06.12.22



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

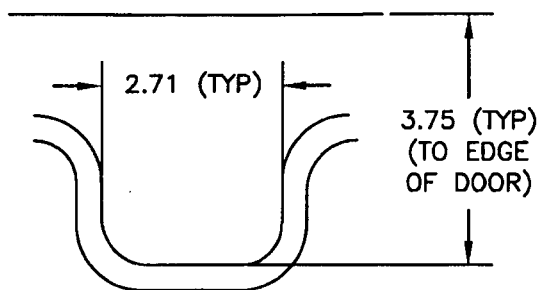
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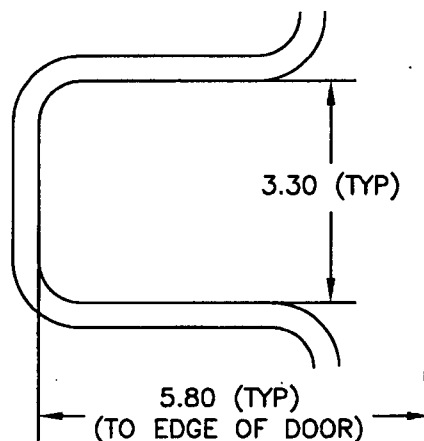
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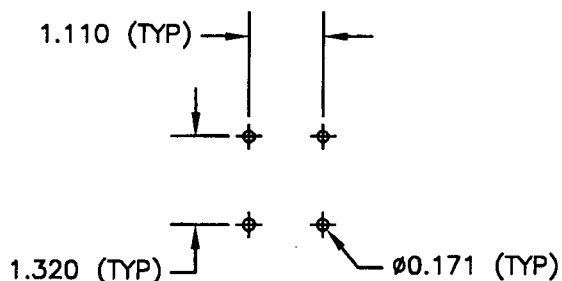
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



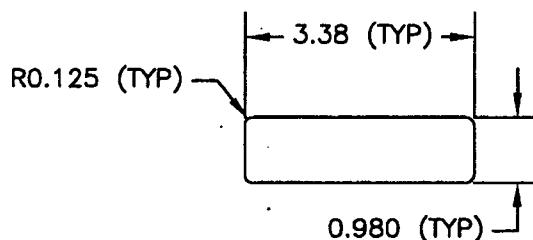
DETAIL A



DETAIL B

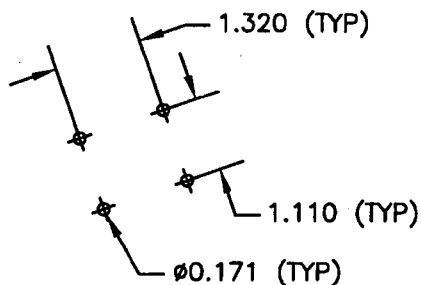


DETAIL C

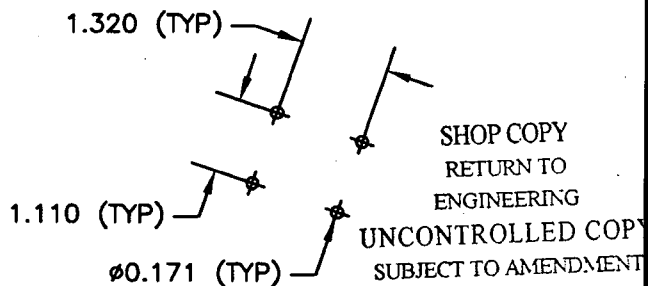


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:

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06.12.22



DELASTEK COMPOSITES INC.
2699, 5ème Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice # 11897

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
03/05/2007	21/12/2006	5092	C. Lavoie	PO00002767			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30012 Dwg. Rév.: C Job: 41396 <i>mul07/05/09</i> U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30022 Dwg. Rév.: C Job: 41110 <i>✓</i> U de M : Each			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30032 Dwg. Rév.: C Job: 41327 U de M : Each			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30042 Dwg. Rév.: C Job: 41100 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Mercredi, 2007-04-11 13:42:19
 Utilisateur: Sylvie Hamel

Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	SPACEPOD DOOR
Numéro Job :	41396	Numéro Article :	DKC134-0052
Numéro Soumission :	2584	Numéro Dessin :	D3186
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2007-04-11	Révision dessin :	C
Prsht Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-350
Prem. fois :	-	Date Dûe :	2007-04-13
Job précédente :	41325	Qté:	1 UdM: UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Dart Aerospace : D31861M		



Process Sheet Rev.: 01 Modification générale selon informations de l'ingénierie

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------

Commentair Qty.:	0.020 GALLON(s)/Unit	Total :	0.020 GALLON(s)
Frekote 44NC			

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup:	0.00Hrs/ Run:	5.0000Min	Total Run :	0.0833Hrs
PRÉPARATION DU MOULE				

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

 Date: 16/04/07 Heure Début: 8:00 Heure Fin: 11:00 Sceau: 

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.:	3.28 VERGE(s)/Unit	Total :	3.28 VERGE(s)
Tissu à délaminer Release ply B			

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.:	3.59 VERGE(s)/Unit	Total :	3.59 VERGE(s)
Wrightlon 5200 Bleu P3			

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.:	3.00 VERGE(s)/Unit	Total :	3.00 VERGE(s)
Feutre de drainage N° Airweave N 10			

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.:	3.00 VERGE(s)/Unit	Total :	3.00 VERGE(s)
Stretchlon 200 poche à vide Vert			

Date: Mercredi, 2007-04-11 13:42:20
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART-- Dart Aerospace Ltd.
Numéro Job: 41396

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish
-----	---------	---

Commentair Qty.: 4.500 VERGE(s)/Unit Total : 4.500 VERGE(s)
9.7 oz Weave #FG-778150-125Y Volan Finish

1-6030-1

8.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
-----	--------	-----------------------------------

Commentair Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)
Ruban à gommer jaune #: T/AT-200Y

9.0	AAC0443	Fiberglass 12 oz Unidirectional
-----	---------	---------------------------------

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)
Fiberglass 12 oz Unidirectional N° de Lot: 5455

10.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe :

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 6/04/07 Heure Début: 8:00 Heure Fin: 10:00 Sceau:



11.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentair Qty.: 0.0080 PINTE(s)/Unit Total : 0.0080 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 5921

12.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6086-1

13.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 17/04/07 Heure Début: 10:55 Heure Fin: 11:00 Sceau:



Date: Mercredi, 2007-04-11 13:42:20
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41396

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

14.0	LAMINAGE.	LAMINAGE PIÈCE DART
------	-----------	---------------------



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8005 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: 17/04/07 Heure Début: 11:00 Heure Fin: 11:20 Sceau:



15.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 17/04/07 Heure Début: 11:20 Heure Fin: 11:40 Sceau:



Curing Début: 11:00 AM Curing Fin: 4:00 PM

16.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentaire Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6086-1

Date: Mercredi, 2007-04-11 13:42:20

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART ___ Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41396

Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: 18/04/07 Heure Début: 12:30 Heure Fin: 1:00 Sceau:

19.0	DKC134-0056	Foam Core N° D3186-101 (Porte D3186-1)
------	-------------	--

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-101 (Porte D3186-1)

1-5826-1

20.0	AAC0452	Polybond B46F
------	---------	---------------

Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)

Polybond B46F

N° de Lot: 5979

21.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART
------	--------------	--------------------------



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0056 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: 18/04/07 Heure Début: 2:30 Heure Fin: 2:50 Sceau:

22.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage

Date: Mercredi, 2007-04-11 13:42:20

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41396

Numéro Article: DKC134-0052

Numéro Job:



Séq.:

Machine ou Opération:

Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond.

Date: 18/04/07 Heure Début: 2:50 Heure Fin: 3:00 Sceau:



Curing Début: 2:30 PM Curing Fin: 8:00 AM

23.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total: 0.0400 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

24.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total: 1.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6005-1

25.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 20/04/07 Heure Début: 12:30 Heure Fin: 12:35 Sceau:



26.0

LAMINAGE.

LAMINAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte .

Faire le laminage du dernier pli de 9.7 oz.

Date: 20/04/07 Heure Début: 12:35 Heure Fin: 1:05 Sceau:



Date: Mercredi, 2007-04-11 13:42:20
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41396

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

27.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------




Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 20/04/07 Heure Début: 1:05 Heure Fin: 1:20 Sceau: 

Curing Début: 12:35 PM Curing Fin: 8:00 AM

28.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
------	-------------	----------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE DES PIECES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule pour éliminer le fini lisse de celui-ci


Date: APR 23 2007 Heure Début: 2:30 Heure Fin: 2:35 Sceau: 

29.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
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Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: APR 23 2007 Heure Début: 2:35 Heure Fin: 2:45 Sceau: 

30.0	AAC0671	Dupont Primer N° 1104S
------	---------	------------------------

Commentaire Qty.: -0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)
Dupont Primer N° 1104S

Date: Mercredi, 2007-04-11 13:42:20

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41396

Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

31.0	AAC0670	Dupont Activator N° 7975S
------	---------	---------------------------

Commentair Qty.: 0.2800 PINTÉ(s)/Unit Total : 0.2800 PINTÉ(s)
Dupont Activator N° 7975S

32.0	AAC0672	Dupont Reducer N° 12375S
------	---------	--------------------------

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S

33.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Nettoyages Qty 1 24-04-07



APR 24 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0	PEINT/PRIMER2	PEINTURE / PRIMER DART
------	---------------	------------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer la première couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon I.G. #
Application du primer.

Laisser sécher pendant 3 heures.

APR 24 2007

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____



35.0	FINITION 3	FINITION PIÈCE DART
------	------------	---------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sabler la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfections et enlever le lustre du primer.

36.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens
------	--------	----------------------------------

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

Date: Mercredi, 2007-04-11 13:42:20

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41396

Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

37.0 AAC0646 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.050 KIT(s)/Unit Total : 0.050 KIT(s)
MASTIC POLYSTOP SIKKENS 3AR591

38.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)
Durcisseur Polysoft #004009 Sikkens N° de Lot: 1-6044-1

39.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de sikkens.

Date: 25-4-07 Heure Début: _____ Heure Fin: _____ Sceau:



40.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-6005-2

41.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-6005-1

42.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5692-2

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Nettoyages aty 1 26-04-07
APR 26 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

44.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
APPLICATION DE PRIMER

Appliquer la deuxième couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. #
Application du primer

APR 26 2007

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau:



Date: Mercredi, 2007-04-11 13:42:20

Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41396

Numéro Article: DKC134-0052

Numéro Job:



Séq.:

Machine ou Opération:

Description :

45.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

INSPECTION PIÈCE DART

27-04-07



OK

Emballage

QT 1

27/4/07



Date: Monday, 4/16/2007 2:32:44 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR LH
Job Number : 31811B	
Estimate Number : 12635	
P.O. Number :	Part Number : D31863
This Issue : 4/16/2007 S.O. No. :	Drawing Number : D3186 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 31811C	Material :
Written By :	Due Date : 4/23/2007 Qty: 1 Um: Each
Checked & Approved By : <u>07.04.16</u>	
Comment : Est Rev:A New Issue 07-01-11 EC est rev B rev D dwg 07.03.07 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	31811B01	SPACEPOD DOOR LH
-----	----------	------------------



w/o 30012



Comment: Sub-Component SPACEPOD DOOR LH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

ml 07/05/10

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/10 (1)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/05/11

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.05.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

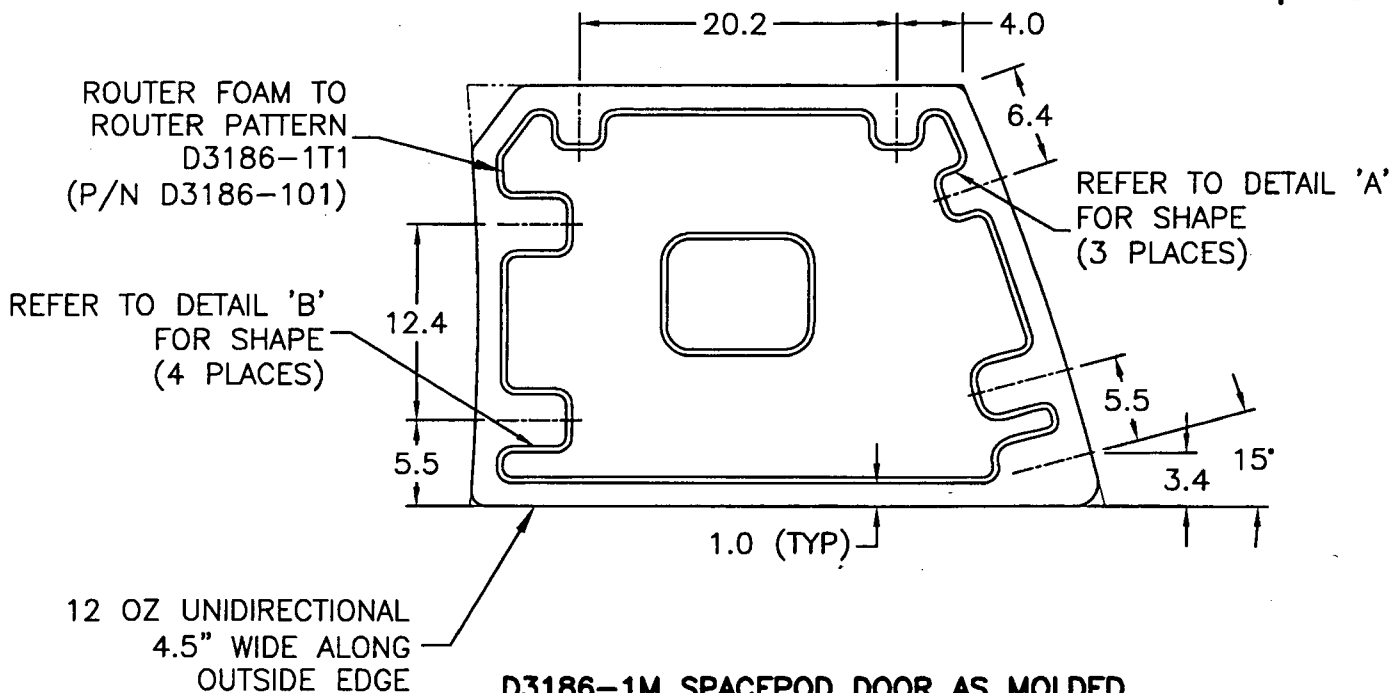
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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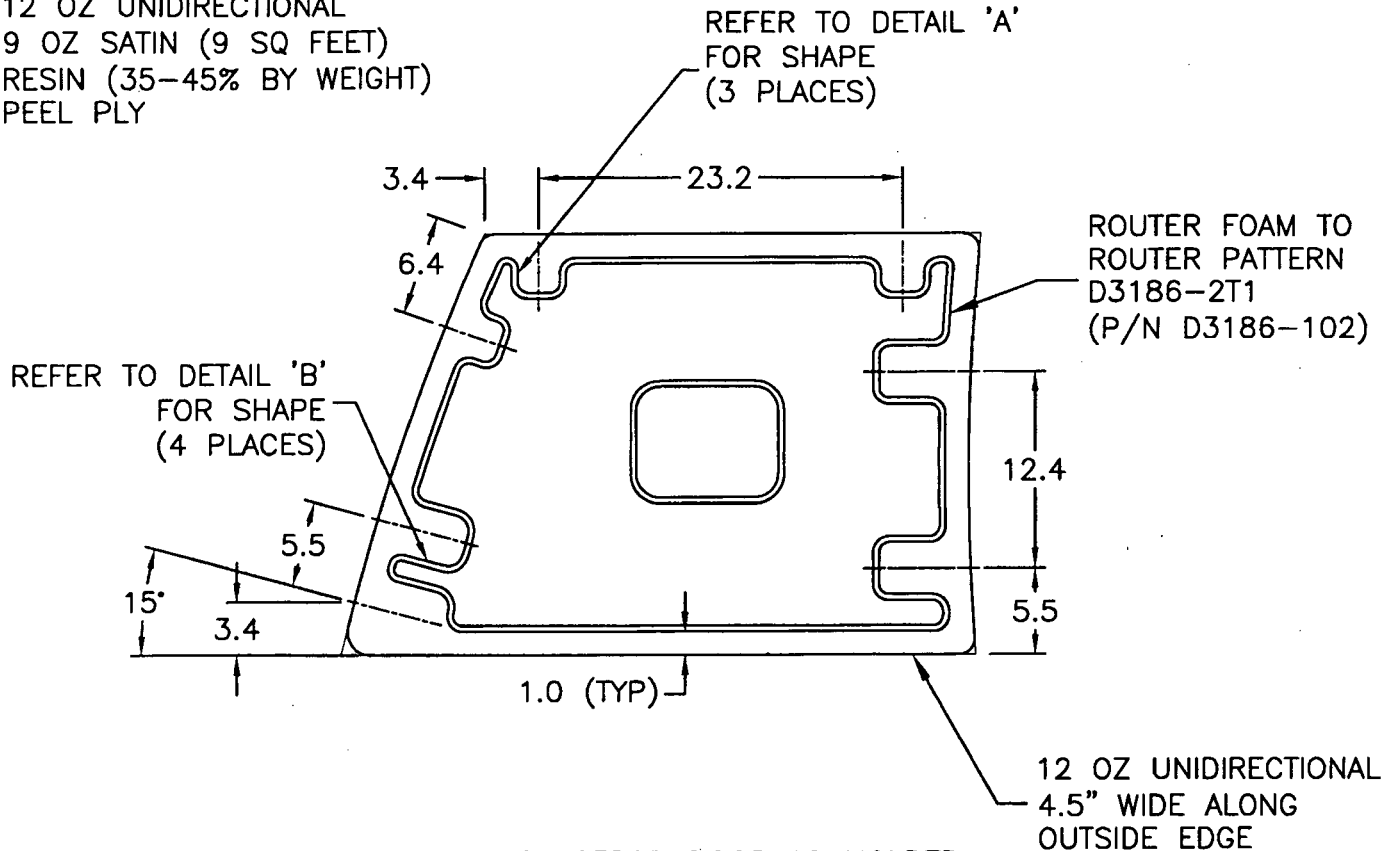
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
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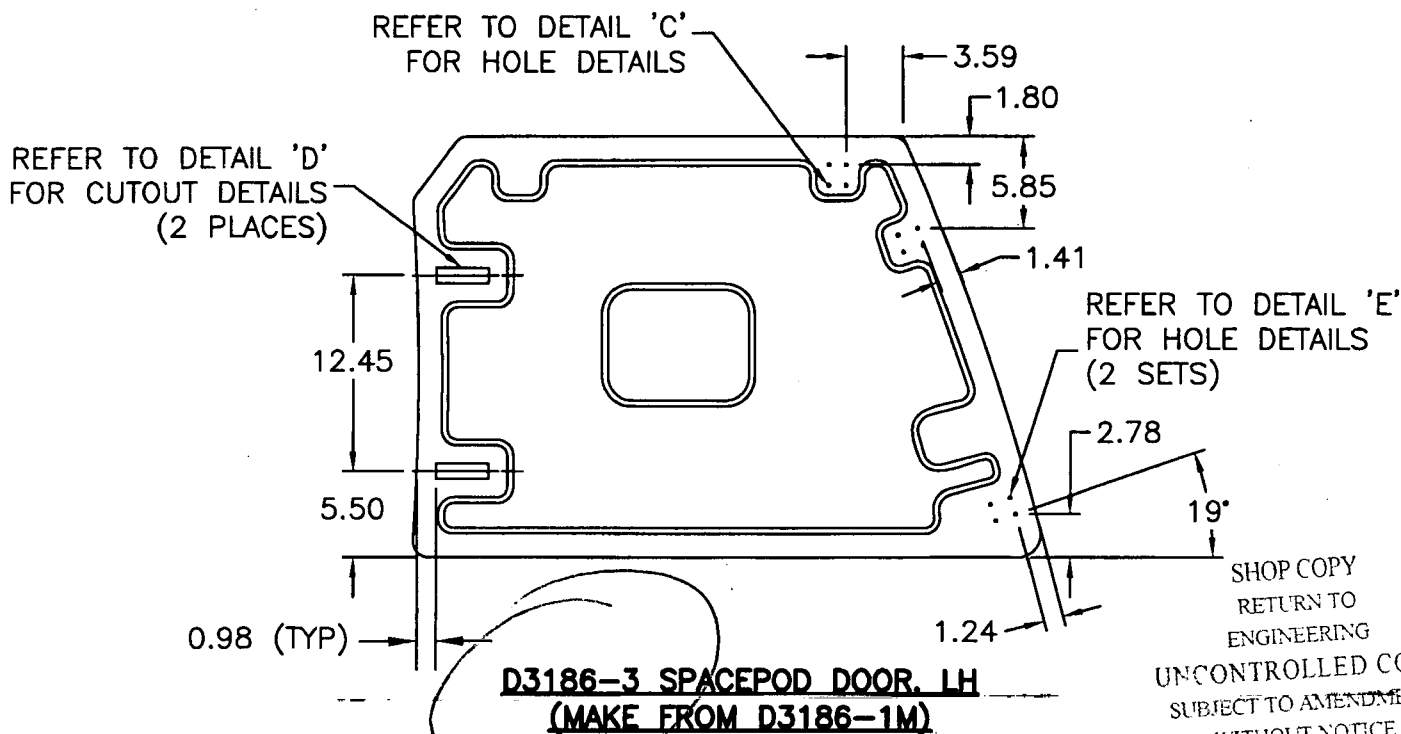
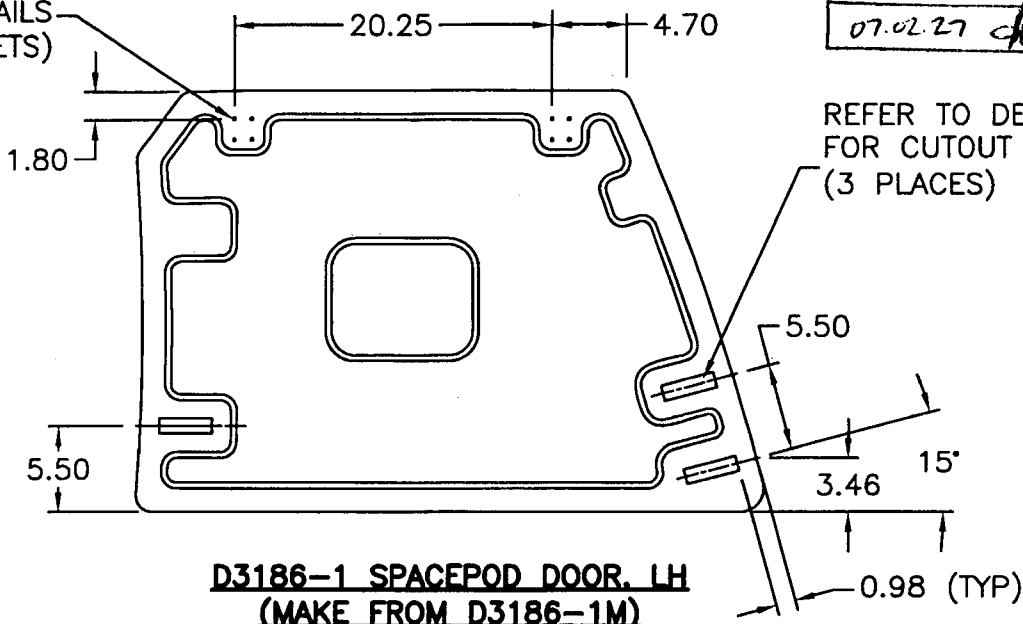
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



NOTES:

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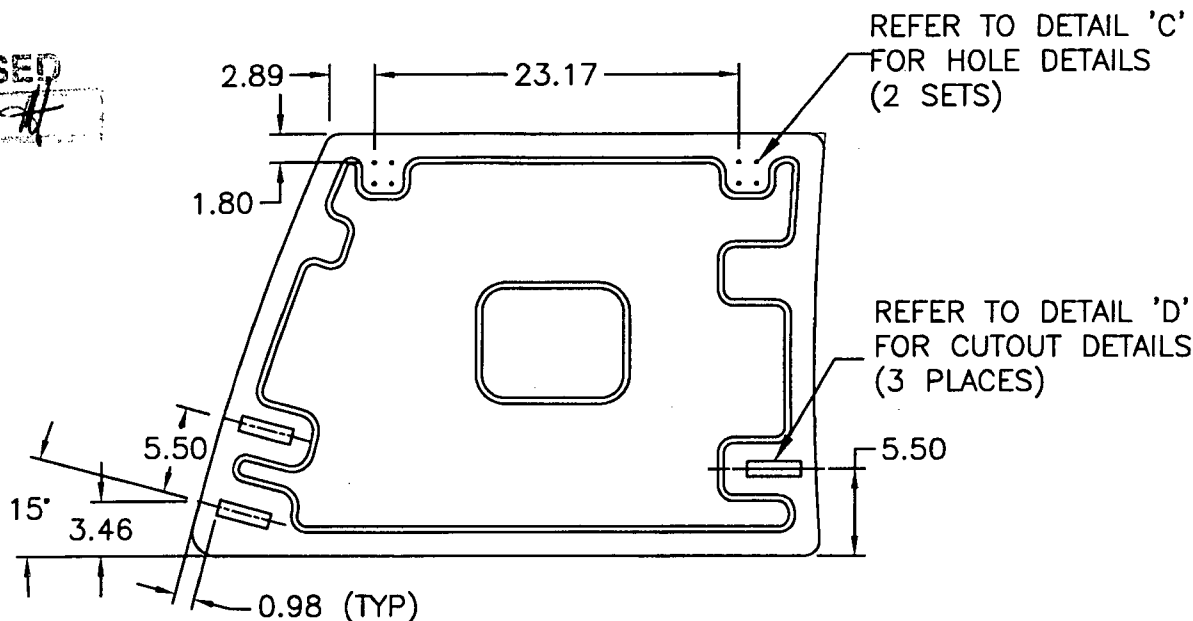
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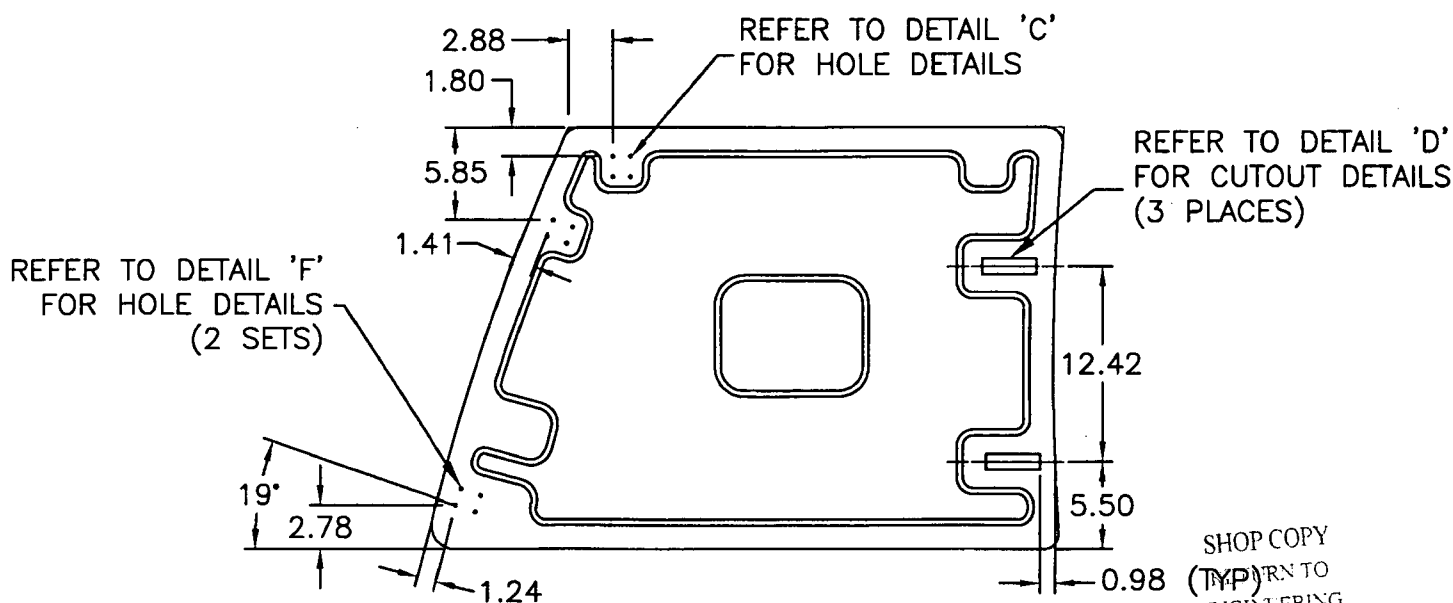


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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
07-02-27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

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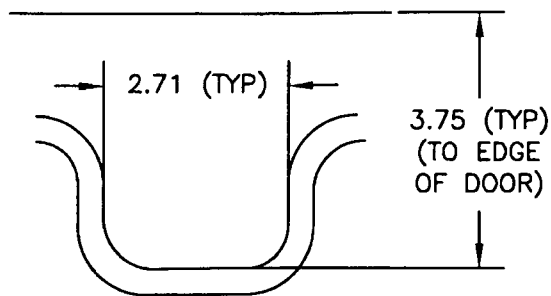
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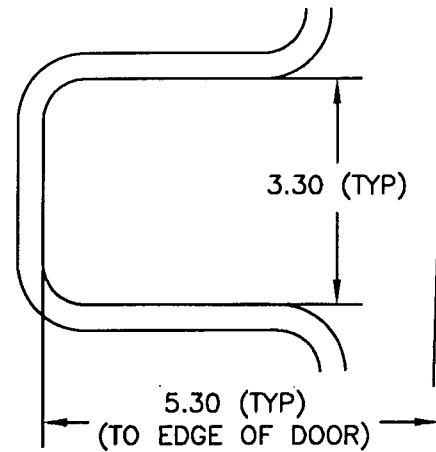
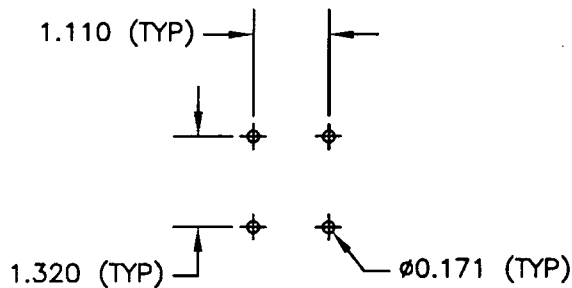
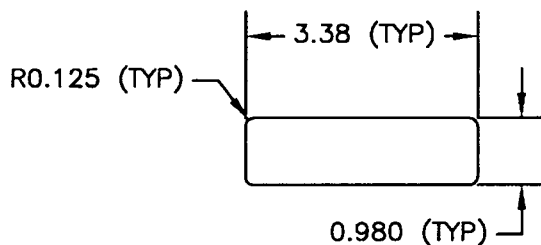
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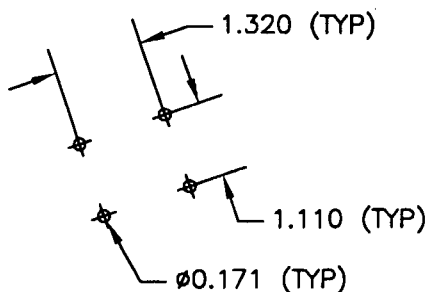
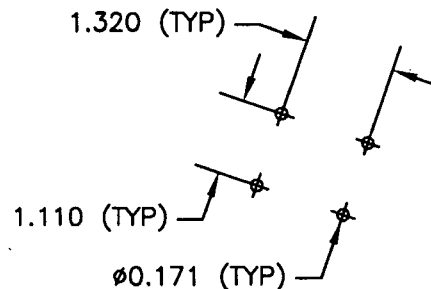
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****RELEASED**

07.02.27 [Signature]

**DETAIL B****DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D**DETAIL E****DETAIL F****NOTES:**

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